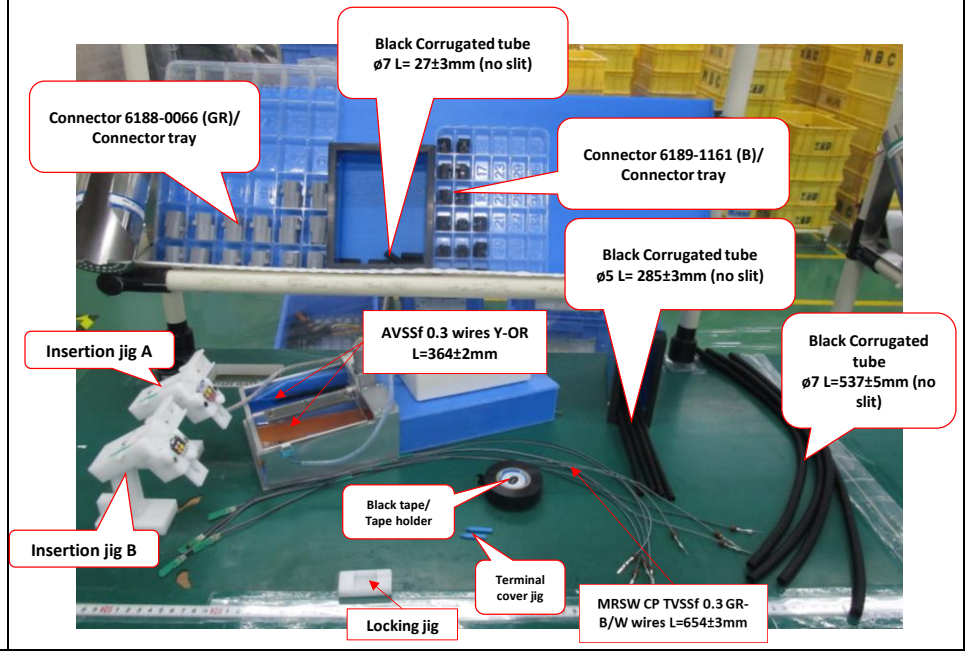
	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	1 of 10

PARTS:	1. All parts: Connector 6188-0066 (GR); AVSSf 0.3 wires Y-OR L=364±2mm; Black Corrugated tube ø7 L=27±3mm (no slit); Connector 6189-1161 (B); Black Corrugated tube ø5 L=285±3mm (no slit); Black Corrugated tube ø7 L=537±5mm (no slit); Black tape [1pc.]	JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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.	*Note: 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
01/06/22	1	Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out; checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.)	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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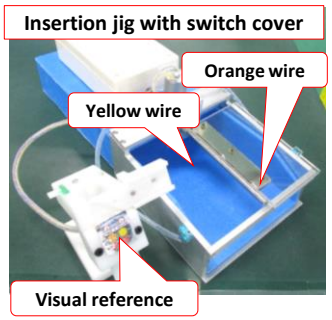
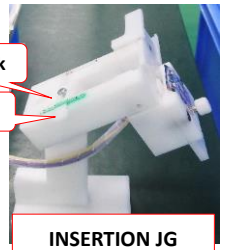
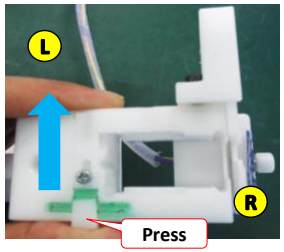
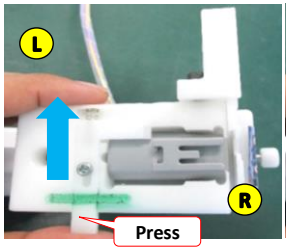
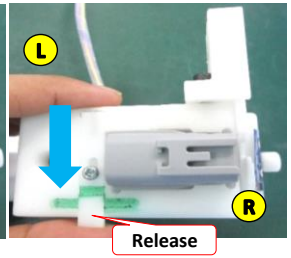
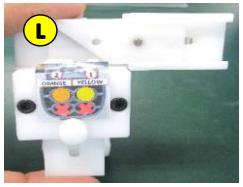
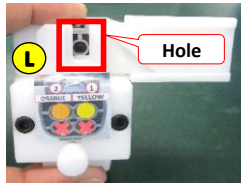
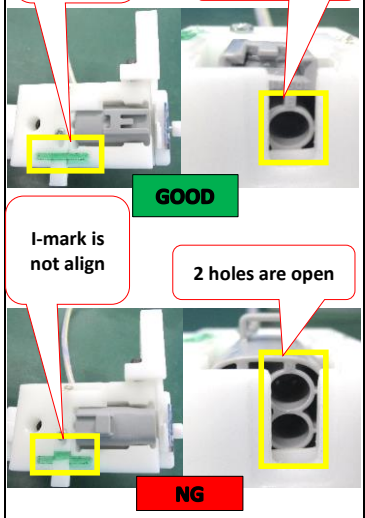
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	2 of 10

PARTS:	1. Connector 6188-0066 (GR)	JIG	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 6188-0066 (GR)	1    1. Press the lock using left thumb.   2. Get the connector **6188-0066 (GR)** using right hand and insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.***   3. Push the lower wire guide upward using left thumb. Slot for **Yellow wire** will be opened.	n/a	1 CONNECTOR ORIENTATION ILLUSTRATION  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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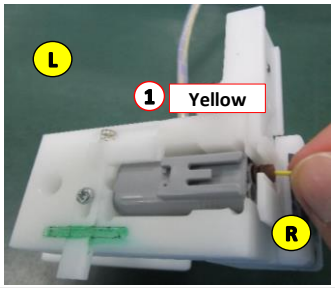
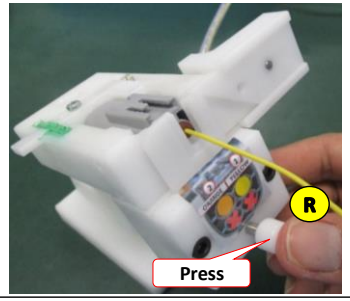
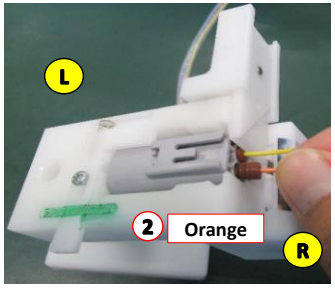
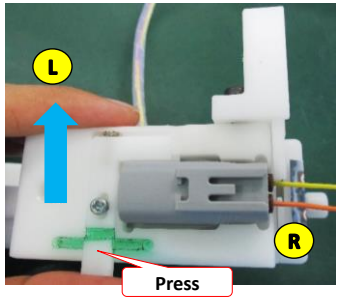
	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	3 of 10

PARTS:	1. AVSSf 0.3 wires Y L=364±2mm; OR L=364±2mm	**JIG**	1. Insertion jig with switch cover

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to connector 6188-0066 (GR)	WIRE FACING  1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot **1** using right hand.  2. Press the button using right thumb. The slot for Orange wire will be opened.  3. Get the Orange wire then insert to terminal slot **2** using right hand.  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.	n/a	*Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* 1 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force. ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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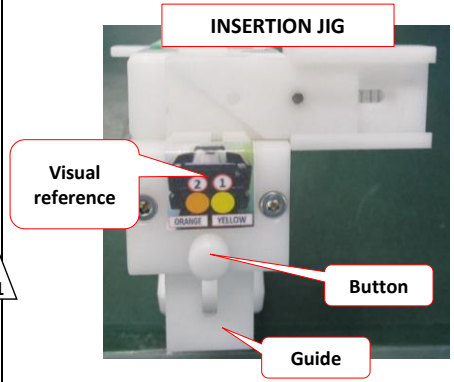
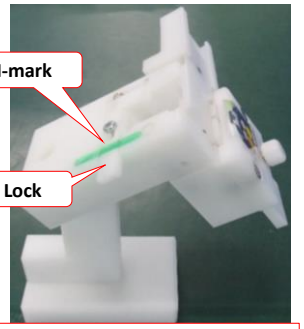
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 Page No.: 4 of 10

PARTS:	1. Black Corrugated tube ø7 L=27±3mm (no slit) 2. Black Corrugated tube ø5 L=285±3mm (no slit) 3. Assy parts	**JIG**	1. Insertion jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to COT (no slit) ø7 L=27±3mm **(1ST)** ø5 L=285±3mm **(2ND)**	 1. Hold the wires using left hand. Get the Corrugated tube (no slit) ø7 L=27±3mm using right hand then insert the Y-OR wires using left hand. 2. Hold the wires using left hand. Get the Corrugated tube (no slit) ø5 L=285±3mm using right hand then insert the Y-OR wires using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal
5		Connector setting to insertion jig 6189-1161 (B) 1	  INSERTION JIG ORIENTATION CONNECTOR ORIENTATTON	n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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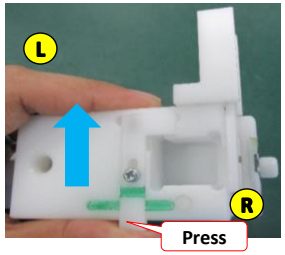
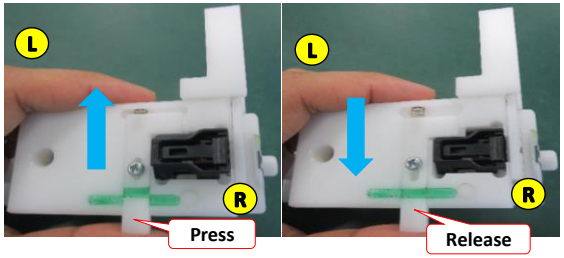
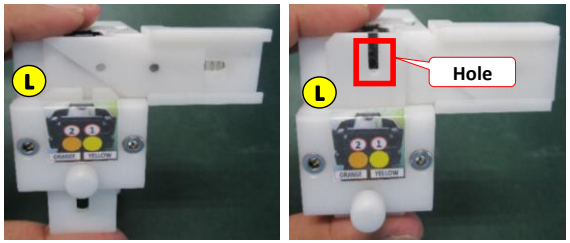
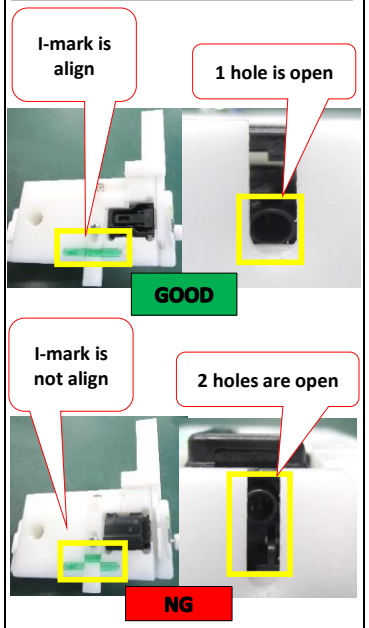
	Model Code/Part Number: 178D / 7N0128-7020	Customer: TRJ		Document No.:	WI-ENG-PDE-331A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 10

PARTS:	1. Connector 6189-1161 (B)	JIG	1. Insertion jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Connector setting to insertion jig 6189-1161 (B) (Continuation)	1  1. Press the lock using left thumb.  2. Get the connector **6189-1161 (B)** using right hand and insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.***  3. Push the lower wire guide upward using left thumb. Slot for **Yellow wire** will be opened.	n/a	1 CONNECTOR ORIENTATION ILLUSTRATION  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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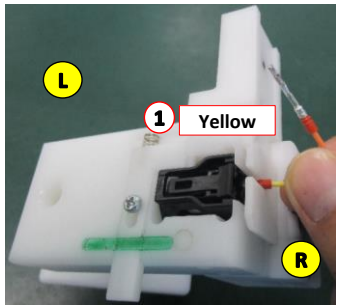
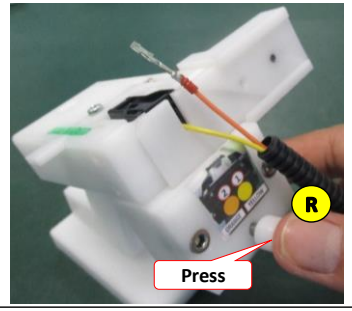
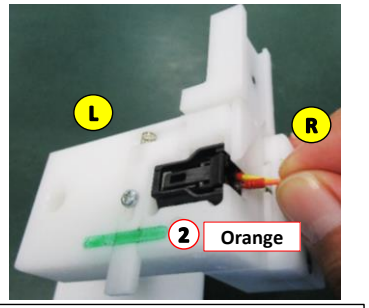
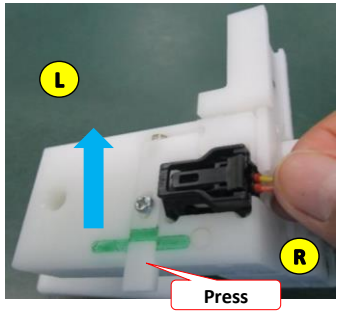
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	6 of 10

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to connector 6189-1161 (B)	 1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot **1** using right hand.  2. Press the button using right thumb. The slot for Orange wire will be opened.  3. Get the Orange wire then insert to terminal slot **2** using right hand.  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.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force. ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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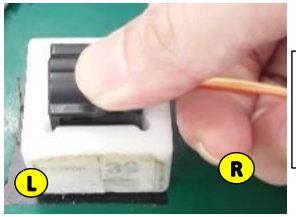
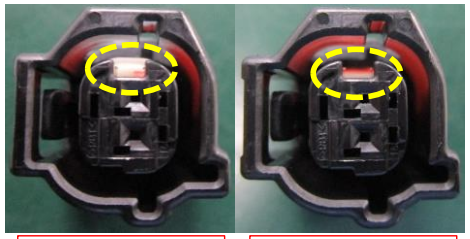
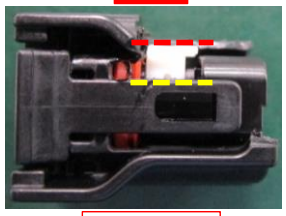
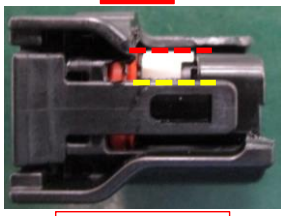
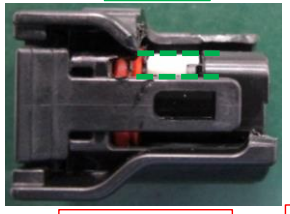
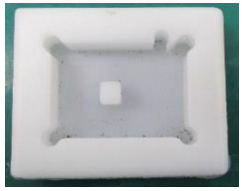
PARTS:	1. Assy parts	**JIG**	1. Locking jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock	1  1. Put the connector into locking jig and push down **2x** using both hands. Check the connector lock if properly locked.  BEFORE PRESSING AFTER PRESSING GOOD NO GOOD NG  UNLOCK CONDITION NG  HALF LOCKED CONDITION GOOD  FULLY LOCKED CONDITION	LOCKING JIG 	1 *Note:* *MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK.* 1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock

NOTE: SET ASIDE THE ASSY PARTS

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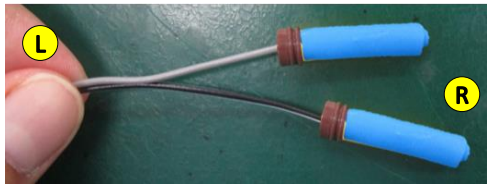
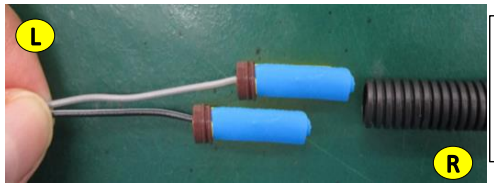
	Model Code/Part Number: 178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 8 of 10

PARTS:	1. MRSW CP TVSSf 0.3 GR-B/W wires L=654±3mm 2. Black Corrugated tube ϕ7 L=537±5mm (no slit)	**JIG**	1. Terminal cover jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Wire insertion to Black Corrugated tube ϕ7 L=537±5mm (no slit)	 1. Get the **MRSW CP TVSSf 0.3 GR-B/W wires L=654±3mm** using left hand, then get the terminal cover jig using right hand then insert to both terminals **(GR-B/W wires)** using right hand.  2. Get the corrugated tube **ϕ7 L=537±5mm** using right hand then insert the **GR-B/W wires** using left hand. 3. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG 	1 *Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* 1. No wrong usage of parts 2. No damaged rubber seal

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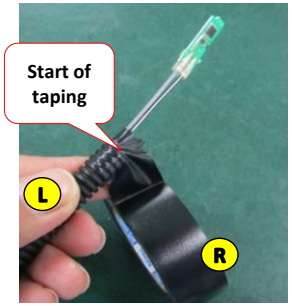
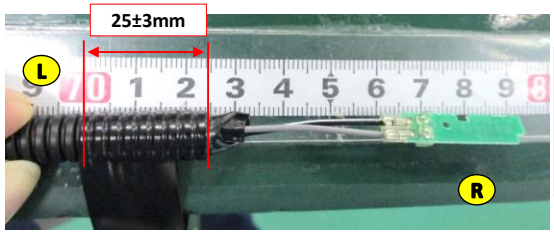
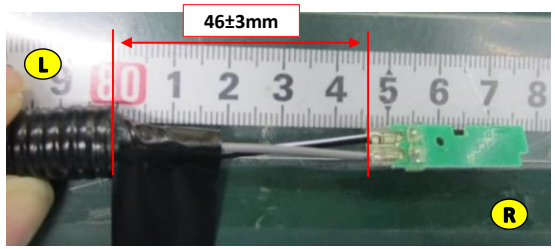
PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Taping 1 Black corrugated tube to wire near PCB	1  1. Hold the assy parts using left hand, get **Black tape** then conduct pre-taping using both hands.  2. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands.  3. Measure from end of COT up to edge of hotmelted wires **46±3mm** then continue the taping process using both hands.	n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape ***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.*

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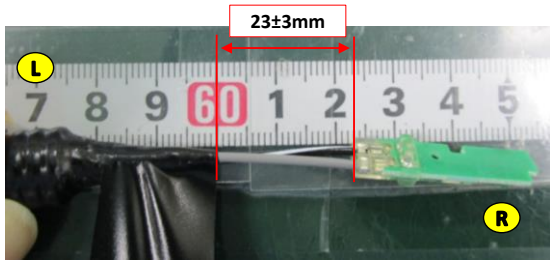
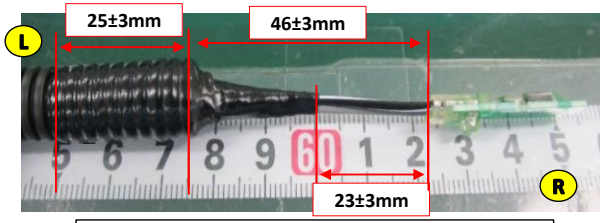
	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	10 of 10

PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	Taping 1 Black corrugated tube to wire near PCB (Continuation)	 4. Confirm measurement of **23±3mm** from end of tape up to edge of PCB then continue the taping process using both hands.  5. After taping, check the measurement and taping condition.		1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape ***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.*

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