				WORK INS	TRUCTION				Effe	ctivity Date:		July 17, 202	1
		Process Name/Title:		TAPING	ASSEMBLY PROC	ESS			Vali	dity Date:		n/a	
		Product Name/Code:	900B /	7N0114-7020A	Customer:	TRJ			Doc	ument No.:		WI-ENG-PDE-2	74A
		Purpose:	☐ PROTOT	YPE	PRE-LAUNCH	MASSPF	RO		Rev	ision No.:	1	Page No.:	1 of 13
	T										T		
PARTS:	(GR); Co				28±2mm; Black vinyl tube Ø7 wire L=800mm; Black vinyl tu				Ø5	JIG:	<ol> <li>Inserti</li> <li>Lockir</li> <li>Termi</li> </ol>		
NO.	PR	OCESS NAME		WORK PR	ROCEDURE/ ILLUSTR.	ATION				TOOLS/PPE		QUALITY POIN	ITERS
1	P1	Table Lay-out	Black vinyl tube Ø7 L=189±3mm  Assy pal  Insertion jig B; C	6188-0066 (GR)	AVSSf 0.3 G-B wires L=677mm	Connector 6098-3810 (1	W)	k vinyl tube L=69±3mm		Safety Instruction  Be sure to wear required personal protective equipme during operation (gloves, finger cots etc.)  Housekeeping  1. Maintain and alway practice 5's.  2. Personal things of the workplace is prohibited. Keep it  Alert level  For any trouble, info the Assembly Assista Supervisor or Line Leader for immedia corrective action.	nt int int int int int int int int int i	ssing parts/tools cess parts/tools ong position of parts/t	ools
				Revision History						Prepared by	Reviewed by	Approved by	Noted by
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07/12/21 0	Initial issu	of validity date. Change docu	ument status from pre-	-iaurich to masspro.		· · ·	-		A. Arañes A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date Rev. No		· <del>·</del>	Details	of Change			Checked	Approved	Noted		July 12, 2021	7. S. amamara	2 7.1.7.10100
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				WORK INSTRU	CTION		Effectivity Date:	July 17, 2021
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		Purpose:	PROTOTYP	E	PRE-LAUNCH	MASSPRO	Revision No.:	1 Page No.: 2 of 13
PARTS:	1. Assy	parts					110	- /-
PARIS:	2. Black						JIG	n/a
NO.	PF	ROCESS NAME		WORK PROC	EDURE/ ILL	USTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Taping 1 Black vinyl tube to wire near connector	1. Measure from end 25±3mm using both 1/3 shifting using both hands.	going to wires  25 ± 3mm  0~5mm	Confirm measur onnector 25±3m ape before cut.	2. Get the Black tape using right hand then start taping process using both hands.  25 ± 3mm  R  rement from end of vinyl tube up to edge of musing both hands. Make 3 windings of  3. After taping, check the measurement and taping condition.	MEASURING TAPE  6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 10 10 10 10 10 10 10 10 10 10 10 10	NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINE, BUT ACTUAL SHOULD BE BLACK.  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  Note: Please use calibrated/verified measuring tape when getting the measurement.

					WORK INSTRUCT	TION			Effectivity Date:			July 17	, 2021
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		Purpose:	PR	OTOTY	PE	PRE-LAUNCH	ı	MASSPRO	Revision No.:		1	Page No.:	3 of 13
PARTS:		parts vinyl tube Ø7 L=189±3mı ector 6188-0066 (GR)	m							JIG	1. Term	inal cover jig	
NO.	Pi	ROCESS NAME			WORK PROCED	URE/ ILLU	STRATION		TOOLS/I	PPE	Q	<b>UALITY F</b>	POINTERS
3	P1	Wire insertion to Black vinyl tube Ø7 L=189±3mm			R	2. Get the viny hand then inso	yl tube <b>Ø7 L=189</b>	±3mm using right es using left hand.	TERMINAL CO	VER JIG		rong usage c amaged rubb	
4		Connector setting to insertion jig 6188-0066 (GR)	Wire guide	Holes	Visual Reference		JIG ORIENTATION	CONNECTOR ORIENTATION	n/a		2. No w 3. No w		

				WORK INSTRUCT	ION		Effectivity Date:		July 17,	2021
	Process Name/Title:			TAPING ASSI	EMBLY PR	OCESS	Validity Date:		n/	а
	Product Name/Code:	900B	1	7N0114-7020A	Customer:	TRJ	Document No.:		WI-ENG-PD	E-274A
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PARTS: 1. Assy parts JIG 1. Insertion jig PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE **QUALITY POINTERS** NO. **Connector Orientation Illustration** I-mark is 1 hole is open 2 holes are I-mark is open **NOT** align 1. Press the lock of insertion jig 2. Insert the connector 6188-0066 (GR) into jig using right hand using left thumb. Connector setting to then release the lock. Note: Follow the connector orientation. 5 insertion jig n/a 6188-0066 (GR) 3. Push the guide using right thumb. The slot for Y wire will be opened. 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 INSTRUCT	ION
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	Product Name/Code:	900B /	7N0114-7020A	Customer:
	Purpose:	☐ PROTOTYPE		PRE-LAUNCH

RTS:	1. Assy pa	arts					JIG	1. Insertion	jig	
NO.	PR	OCESS NAME	WORK PRO	CEDURE/ ILLUSTRA	TION	TOOLS/I	PPE	QUA	LITY P	OINTERS
6	P1	Wire insertion to Connector 6188-0066 (GR)	1. Hold the insertion jig using left hand. Get the assy parts, insert the Yellow wire to connector slot 1 using right hand.  Orange  R  3. Get Orange wire then insert to connector slot 2 using right hand.	for Orange wire  4. After insert thumb and the	con using right thumb, slot will be opened.  In the state of the state	n/a		1. No loose 2. No wron 3. One by 0 4. No defor 5. No wron	e insertion g insertion one insert one insert med term g wire fac	n ion iinal sing

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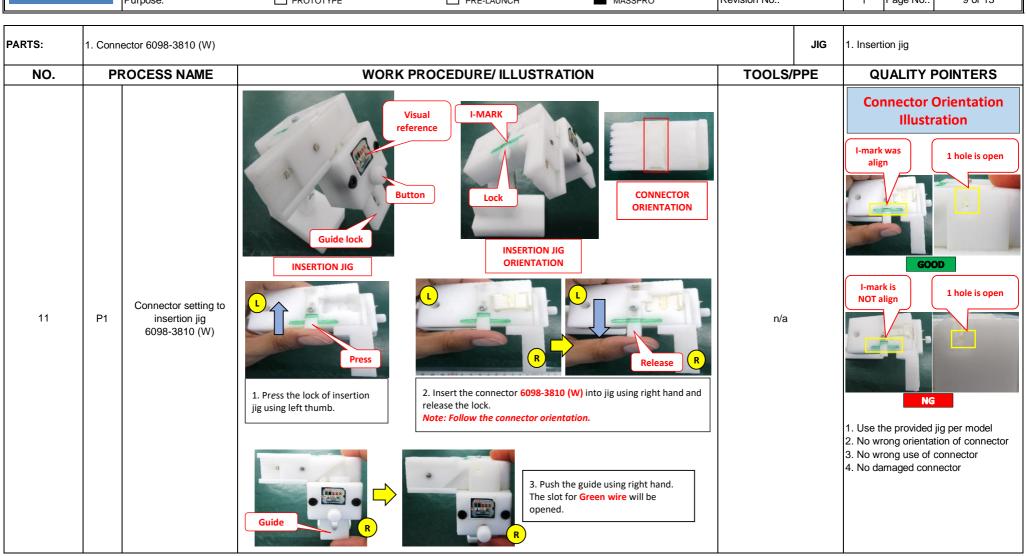
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					WORK INSTRUCT	TION		Effectivity Date:			July 17,	2021
		Process Name/Title:			TAPING ASS	EMBLY PROCES	S	Validity Date:			n	/a
		Product Name/Code:	900B		7N0114-7020A	Customer:	TRJ	Document No.:			WI-ENG-PI	DE-274A
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										•		
PARTS:	1. Assy 2. AVSS	parts of 0.3 V wire L=800±3mm							JIG	1. Lockir	ng jig	
NO.	PF	ROCESS NAME			WORK PROCED	OURE/ ILLUSTRATIO	N	TOOLS/	PPE	QI	JALITY P	OINTERS
7	P1	Wire insertion to connector 6188-0066 (GR)		NECTOR		1. Get the Violet wire the right hand. Note: Folow the connection	1 Violet R en insert to empty slot using tor orientation.	n/a		1. No loc 2. No wr 3. One b 4. No de 5. No wr	ose insertion rong insertion by one inserti formed term rong wire fac	n ion inal ing -PRO-ASY-029
8		Connector Lock	1. Put the clocking jig uthen press connector locked.	using righ <mark>2x.</mark> Touc	nt hand th the	NG Unlock Condition	NG GOOD  Half Lock Condition  Cross Sectional View  GOOD  Full Lock Condition	LOCKING	JIG	1. Use the model	IUAL LOCKIN IAGED LOCK.	ocking jig per

					W	ORK INSTR	UCT	TION				E	Effectivity Date:			July 17	', <b>202</b> 1	
		Process Name/Title:				TAPING A	SSI	EMBLY	/ PRC	CESS		\	/alidity Date:			ļ	n/a	
		Product Name/Code:	90	0B /	7N(	0114-7020	Α	Customer	r:	Т	RJ	[	Document No.:			WI-ENG-F	DE-274A	
		Purpose:		PROTOTY	PE			PRE-LAUNG	СН		MASSPRO	F	Revision No.:		1	Page No.:	7 of	f 13
												<u> </u>		_		I		
PARTS:	1. Assy 2. Black													JIG	1. Lockir	ng jig		
NO.	PF	ROCESS NAME			V	WORK PRO	CED	URE/ IL	LUST	RATION			TOOLS/	PPE	QI	JALITY I	POINTE	RS
9		Wire insertion to assy parts Black vinyl tube Ø7 L=189±3mm			19±3mm ւ	Ø7 L=189±  L  e using right han using left hand t t hand.	d, hold	d the vinyl	l		R		n/a			ong insertic formed tern		
10	P1	Taping 2 Black vinyl tube to wire near connector	L	9 60	25±3m	2			to both	edge of con th hands.	m end of vinyl tube up nector <b>25±3mm</b> using sing right hand then ng both hands.		MEASURIN 6 7 8 9 (1) 1 2 3 6 1 2 3 6 1 3 3 7 8 9	1 5 6 7 8 9	1. No flip 2. No pe 3. No loc 4. No mi 5. No wr 6. No wr  Note: measu	D-out tape elel-off tape ose tape ssing tape ong dimens	SHIFTING I  LD BE BL  tape  ion	ACK.

					WORK INSTRUCT	TION			Effectivity Date:			July 17	, 2021
		Process Name/Title:			TAPING ASS	EMBLY P	ROCES	S	Validity Date:			r	n/a
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	1	•							•				
PARTS:	1. Assy 2. Black									JIG	n/a		
NO.	Р	ROCESS NAME			WORK PROCED	URE/ ILLU	STRATIC	ON	TOOLS/	PPE	QI	JALITY F	POINTERS
10	P1	Taping 2 Black vinyl tube to wire near connector (Continuation)	L 8 25 ±	1/3 sh		both har	4. Confirm vinyl tube to 25±3mm us windings o	going to wires using  measurement from end of up to edge of connector using both hands. Make 3 of tape before cut.	6 7 8 9 1 2 3 4	5 6 7 8 9 6	1. No flip 2. No pe 3. No loc 4. No mi 5. No wr 6. No wr	p-out tape ele-off tape ose tape issing tape rong use of t	EALACK.  Lape  Lap

	_			WORK INSTRUCT	TION		Effectivity Date:		July 17	. 2021
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PARTS: 1. AVSSf wires G and B wires L=677±3mm JIG 1. Insertion jig **WORK PROCEDURE/ILLUSTRATION** NO. **PROCESS NAME** TOOLS/PPE **QUALITY POINTERS** WIRE FACING Note: Please hold the wire near terminal during insertion. Button Green 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 1. Hold the insertion jig using left 5. No wrong wire facing 2. Press the button using right thumb, slot hand, get **Green wire** and insert to Wire insertion to for Black wire will be opened. connector slot 1 using right hand. P1 12 Connector n/a 6098-3810 (W) Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure. Black 4. After insertion, push the lock using left thumb 3. Hold the insertion jig using left and then hold the wires and gently pull out the hand, get Black wire and insert to connector slot 2 using right hand. connector from jig using right hand.

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	Dungan Nama (Titler	WORK INSTRUCTION TABLES ASSEMBLY PROCESS	Effectivity Date:	July 17, 2021
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PARTS:	Assy parts     Black vinyl tube Ø5 L=69±3mi	n	JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	Connector lock	Put the connector into locking jig using both thumb then press to lock 2x. Touch the connector lock to confirm if properly pressed.  Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.  Before Pressing  After Pressing  Fully Locked  UnLocked	Locking jig	Note: Use provided jig tool per model to avoid damaged lock.  1. Use the provided locking jig per model 2. No unlock/half-lock connector  NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.

Wire insertion to
Black vinyl tube
Ø5 L=69±3mm



1. Get the vinyl tube 65 L=69±3mm using right hand then insert the G-B wires using left hand.

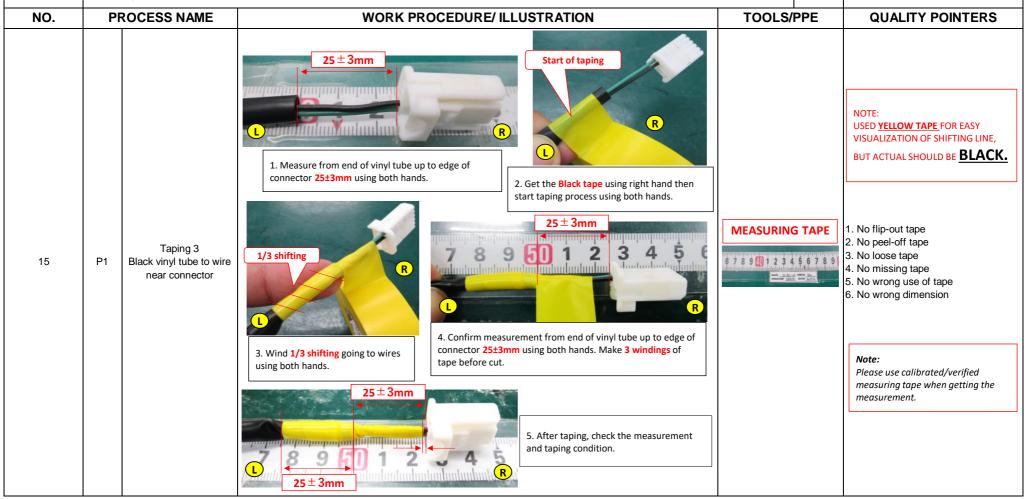
1. No wrong usage of parts

n/a

No deformed terminal

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	1. Assy	parts												
PARTS:	-	Black tape							JIG	n/a				
NO.	Р	ROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
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