										ctivity Date:		June 07, 2021				
		Process Name/Title:		TAPING	G ASSEMBLY PRO	CESS			Valid	lity Date:		n/a				
		Product Name/Code:	101D /	7N0096-7020	Customer:	TRJ			Doc	ument No.:		WI-ENG-PDE-23	38B			
		Purpose:	PROTO	TYPE	PRE-LAUNCH	MASS	PRO		Revi	sion No.:	1	Page No.:	1 of 7			
									1							
PARTS: 1. Assy parts							JIG:	n/a	n/a							
NO.	PR	OCESS NAME		WORK P	ROCEDURE/ ILLUSTR	RATION				TOOLS/PPE	G	QUALITY POINTERS				
1	P2	Wire insertion to assy parts	L Vinyl L=	1. Hold the corrugated then insert the B/B w	d tube (no slit) Ø5 L=171±3mm u	using left hand			2. w	Safety Instruction Be sure to wear prescribed personal protective equipment uring operation (gloves, finger cots, etc.) Housekeeping Maintain and always practice 5's. Personal things on the orkplace is prohibited. (seep it in your locker. Alert level or any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. MEASURING TAPE	1. No wrong 2. No deform	g use of parts med terminal				
			I.	Revision History						Prepared by	Reviewed by	Approved by	Noted by			
											10-11	(a b				
06/07/21 1 03/06/21 0		of validity date. Apply additi	onal note in connecto	r insertion process.		M. Catapang	C.Villanueva	A. Shimamura	A. Arañes	- Almoutage C	JH	Shirk	A. Aranes			
03/06/21 0 Eff. Date Rev. No	Initial issu	JE	Detail	ls of Change		M. Catapang Revised	C.Villanueva Checked	A. Shimamura Approved	A. Arañes Noted		C.VManyeva rch 06, 2021	A. Shimamura	/A. Arraines			
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				WORK INSTRU			Effectivity Date:	June 07, 2021
		Process Name/Title:		TAPING AS	SSEMBLY PR	OCESS	Validity Date:	n/a
		Product Name/Code:	101D /	7N0096-7020	Customer:	TRJ	Document No.:	WI-ENG-PDE-238B
		Purpose:	☐ PROTOT	YPE	PRE-LAUNCH	MASSPRO	Revision No.:	1 Page No.: 2 of 7
<u> </u>	ı							
PARTS:	1. Assy	parts					JIG	1. Insertion jig
NO.	PI	ROCESS NAME		WORK PROC	CEDURE/ ILLUS	TRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Connector setting to insertion jig 6098-3802 (W) (Assy parts)	I. Press the lock using left thumb.	·	INSERTION ORIENTAT	Release 6098-3802 (W) into jig using the lock. ector orientation.	n/a	Connector Orientation Illustration I-mark is align 2 Holes are open GOOD 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

			WORK INSTRUCT	ΓΙΟΝ		Effectivity Date:		June 07,	2021
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Produc	ct Name/Code: 10	1D /	7N0096-7020	Customer:	ΓRJ	Document No.:		WI-ENG-PD	E-238B
Purpos	se:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	3 of 7

1. Insertion jig PARTS: JIG 1. Assy parts 2. Locking jig **PROCESS NAME** NO. **WORK PROCEDURE/ILLUSTRATION** TOOLS/PPE **QUALITY POINTERS** Wire facing 1. No loose insertion Wire insertion to 2. No wrong insertion connector 3 n/a 3. One by one insertion 1. Get the assy part and hold the **B wire** 6098-3802 (W) 2. Hold the **B wire** then insert to terminal 4. No deformed terminal then insert to terminal slot 1 using right (Assy parts) slot 2 using right hand. 5. No wrong wire facing hand. Note: Make sure wires are properly inserted. P2 Conduct Pull-Push-Pull-Push after 3. After insertion, push the lock using left insertion. thumb and then hold the wires and gently pull Do not exert extra force. out the connector from jig using right hand. NOTE: MANUAL LOCKING MAY CAUSE **GOOD** NG DAMAGED LOCK. **LOCKING JIG** Before pressing 1. Use the provided locking jig per Connector lock model 2. No unlock/half-lock connector 1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly locked. Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock. Full Lock After pressing

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				WORK INSTRUC	CTION		Effectivity Date:	June 07, 2021
		Process Name/Title:		TAPING ASS	SEMBLY PROCE	SS	Validity Date:	n/a
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		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	1 Page No.: 4 of 7
PARTS:	1. Assy 2. Black	•						JIG n/a
NO.	PR	ROCESS NAME		WORK PROCE	DURE/ ILLUSTRA	TION	TOOLS/PP	PE QUALITY POINTERS
5	P2	Taping 1 Black vinyl tube to wire near connector	attach at 25mm i	1. Measure fr connector 25 ape using right hand then n measure of vinyl tube, of tape at vinyl tube using	3. Make 1/2 shiftin wire side then mak the tape. 4. After	5 6 7	6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	4. No missing tape 5. No wrong use of tape 6. No wrong dimension

		D. M. (Till		WORK INSTRU		DOCESS.		Effectivity Date:	June 07	,
		Process Name/Title: Product Name/Code:	101D /		SSEMBLY P			Validity Date: Document No.:	n/s WI-ENG-P	
				7N0096-7020	Customer:		RJ			
		Purpose:	PROTOTYPI		PRE-LAUNCH		MASSPRO	Revision No.:	1 Page No.:	5 of 7
PARTS:	1. Assy 2. Black							JIG	n/a	
NO.	PF	ROCESS NAME		WORK PROC	EDURE/ ILLU	STRATION		TOOLS/PPE	QUALITY P	OINTERS
6	P2	Taping 2 Black Corrugated tube to Black vinyl tube near connector	make 2 windings of COT and vinyl using 1/2 shifting	be using right hand then f tape at the middle of g both hands.	3. Make 1/2 shift other side of cut the tape and cut the	T until it reach 25 of tape before shoting using both hold tube then make tape.	booth hands going to the simm then make 2 sifting to other side.		NOTE: USE YELLOW TA VISUALIZATION LINES, BUT ACT BE BLACK TAPE. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of ta 6. No wrong dimensi Note: Please use calibrate measuring tape whe measurement.	of SHIFTING UAL SHOULD appe on d/verified

				WORK INSTRU	JCTION		Effectivity Date:		June 0	7, 2021
		Process Name/Title:		TAPING AS	SSEMBLY PRO	CESS	Validity Date:	•	n	/a
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		Purpose:	PROTO)TYPE	PRE-LAUNCH	MASSPRO	Revision No.:		1 Page No.:	6 of 7
PARTS:	1. Assy 2. Black							JIG	n/a	
NO.	PI	ROCESS NAME		WORK PROC	EDURE/ ILLUST	RATION	TOOLS/P	PE	QUALITY I	POINTERS
7	P2	Y-Taping	L tape shift	1. Fix t	Corru left si (19m) 3. Wir the ot	Rart taping at the middle of combined agated tubes, then wind the tape to ide, width must be same with tape im) and the tape 1/3 shifting until it reach ther side of corrugated tube (must be width)	n/a		NOTE: USE YELLOW T/ VISUALIZATION LINES, BUT ACT BE BLACK TAPE 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of 6. No wrong dimens	N OF SHIFTING FUAL SHOULD

			WORK INSTRUC	CTION	Effectivity Date:		June 07,	2021
		Process Name/Title:	TAPING AS	SEMBLY PROCESS	Validity Date:		n/a	
		Product Name/Code:	101D / 7N0096-7020	Customer: TRJ	Document No.:		WI-ENG-PD	E-238B
		Purpose:	PROTOTYPE	PRE-LAUNCH MASSPR	Revision No.:		1 Page No.:	7 of 7
PARTS:	1. Assy 2. Black		WORK BROCK	EDURE/ ILLUSTRATION	TOOLS	JIG	n/a QUALITY PO	NATEDE
7	P2	Y-Taping (Continuation)	taping direction tape shifting 1/2 below Tape shifting 9mm below 25±3mm 25±3mm	4. Wind the tape backward 1/2 s 5. Wind the tape 1/2 shifting go other side of corrugated tube th tape. After taping, check the cortape.	MEASURIN 6 7 8 9 10 1 2 3 and to gen cut the	G TAPE	NOTE: USE YELLOW TAP VISUALIZATION O LINES, BUT ACTU BE BLACK TAPE. 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 measuring tape when measurement.	E FOR EASY OF SHIFTING AL SHOULD De