					WORK INST	RUCTION		Effec	tivity Date:		October 07, 2	022	
		Process Name/Title:			TAPING	G ASSEMBLY PR	OCESS	Valid	lity Date:		n/a		
		Model Code/Part Number:	TP1	1	7L0092-7021	Customer:	TRQSS	Docu	ıment No.:		WI-ENG-PDE-0	63C	
		Purpose:	F	PROTOTYPI	Ē	PRE-LAUNCH	MASSPRO	Revis	sion No.:	7	Page No.:	1 of 5	
								ı					
PARTS:	1. Assy 2. Black	parts ctape [1pc.]							JIG:	1. T-Taping	jig		
NO.		PROCESS NAME			WORK P	ROCEDURE/ ILLUS	TRATION		TOOLS/PPE	(QUALITY POINTERS		
1	P3	Table Lay-out		A.S.	sy parts	Table Lay-out	T-Taping jig	p du 1. 2. ww k	Be sure to wear prescribed persona rotective equipme ring operation (glor finger cots, etc.) Housekeeping. Maintain and alwar practice 5's. Personal things on orkplace is prohibit fieep it in your locked and the prescribe of a Assembly Assistation of Line eader for immedia corrective action.	n al lent ves, i ays ! the ed. 2. No excess rm ant	ng parts/tools ss parts/tools		
	ı				Revision History				Prepared by	Reviewed by	Approved by	Noted by	
10/07/22 7	Improve	quality pointers: References in pr	ocess no.2 an	d 4 due to	document improvement.		M. Catapang J. Loterte C. Villanueva	A. Arañes	.,,				
04/12/22 6	Addition	al table layout.					M. Catapang J. Loterte C. Villanueva	A. Arañes					
02/15/21 5	to wire r	part number from 7L0092-7020A lear connector. Conduct review of	documents.				COT M. Catapang C. Villanueva A. Shimamura	A. Arañes	Huncutapur	Show	S/out) Hours	SANTA	
02/03/21 4		ome improvements. Remove cycle	time in every	process. C	Conduct semi-annual revie	ew of documents.	M. Catapang R. Peñaloza A. Shimamura Revised Checked Approved	A. Arañes	M. Catapang	J. Loverte	C. Villanueva	./ A. Araños	
Eff. Date Rev. No)		D	etails of Ch	Noted	Est. Date:	January 03, 2020						

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					WORK INSTRUCT	TION			Effectivity Date:			October 0	07, 2022
		Process Name/Title:			TAPING ASS	EMBLY	PROCESS		Validity Date:			n/a	a
		Model Code/Part Number:	TP1	1	7L0092-7021	Customer:		TRQSS	Document No.:			WI-ENG-P	DE-063C
		Purpose:	☐ PF	ROTOTYF	PE	PRE-LAUNC	Н	MASSPRO	Revision No.:		7	Page No.:	2 of 5
PARTS:	1. Assy 2. Black									JIG	1. Т-Тар	oing jig	
NO.	P	ROCESS NAME			WORK PROCE	DURE/ IL	TOOLS/	Q	UALITY P	OINTERS			
2	P3	Y-taping	3. Wind th	hifting the tape 1	1. Fix the vinyl tube a taping direction Tape width 1/3 shifting until it reach the tube (must be tape width)	No gap R and corrugated 1/3 shifting mg direction other 4.	Note: Do excessive pulling & 2. Start taping at the n Corrugated tubes and pre-tape before shiftir going to corrugated tu width must be same w Wind the tape backwa 5. Wind the tape 1/2 side of corrugated tubes	vinyl tube, make 1 wind ng then wind the tape ube and vinyl tube, with tape (19mm) Ing direction 1/2 Ind 1/2 shifting. Thifting going to other then cut the tape. condition of tape and	MEASURING 6 7 8 9 10 1 2 3 4 **********************************		1. Use visual actual 2. Plea measu 1. No flij 2. No pe 3. No loo 4. No m 5. No wi	ıl should be <u>E</u> ase use calibro	APE for easy ifting lines, but BLACK TAPE. ated/verified en getting the

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Model Code/Part Number:	TP1	1	7L0092-7021	Customer:		TRQSS	Document No.:		WI-ENG-P	PDE-063C
Purpose:	PROTOTYPE			PRE-LAUNCH		MASSPRO	Revision No.:	7	Page No.:	3 of 5

1. Assy parts 1. T-Taping jig PARTS: JIG 2. Black tape PROCESS NAME **WORK PROCEDURE/ ILLUSTRATION** TOOLS/PPE **QUALITY POINTERS** NO. 1. No flip out tape 2. No tape peeling 3 n/a 3. No loose tape Pre-tape Tape width 4. No wrong use of tape 5. No exposed wire Combined the 2 corrugated tube near terminal then tape 2 winds using right hand. P3 1. No flip out tape No Gap 2. No tape peeling 3. No loose tape 4 T-taping n/a 4. No wrong use of tape 5. No wide interval between COT 6. No exposed wire 1 Arrange the 4 corrugated tube to form inverted T using left and right hand.

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Purpose:	PROTOTYPE			PRE-LAUNCH	MASSPRO	Revision No.:	7	Page No.:	4 of 5	

1. Assy parts PARTS: JIG 1. T-Taping jig 2. Black tape TOOLS/PPE **QUALITY POINTERS PROCESS NAME** NO. **WORK PROCEDURE/ILLUSTRATION** 2 Start taping at the middle to fix the 4 3 Wind the tape from front to back at the Important reminders/Note/s: corrugated tubes using right hand. right side 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. 4 Wind the tape from back to front (cross (5) Wind the tape from front to back at the 1.No flip out tape pattern) 2.No tape peeling left side T-taping P3 n/a 3. No loose tape (Continuation) 4. No wrong use of tape 5. No wrong dimesion 6 Wind the tape from back to front (cross pattern) 8 Tape the right side corrugated tube (3 winds), width must be same as tape (19mm) 7 Repeat the process from 3~6 3 times 9 From the 10 Wind the right side, wind tape from front the tape 2/3 to back side shifting going to (cross pattern) center

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Purpose:	☐ PROTOTYPE			PRE-LAUNCH	MASSPRO	Revision No.:	7	Page No.:	5 of 5

1. Assy parts PARTS: JIG n/a 2. Black tape TOOLS/PPE **QUALITY POINTERS PROCESS NAME** NO. **WORK PROCEDURE/ILLUSTRATION** Important reminders/Note/s: 1. Use YELLOW TAPE for easy 12) From the top side, wind the tape 2/3 11) Tape the top side corrugated tube (3 winds), visualization of shifting lines, but width must be same as tape (19mm) shifting going to center actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. 1.No flip out tape 2.No tape peeling T-taping **MEASURING TAPE** (13) Wind the tape going to front side (14) Wind the tape from front to back side (cross P3 3. No loose tape (Continuation) (cross pattern) pattern) 4. No wrong use of tape 5. No wrong dimesion 6 7 8 9 10 1 2 3 4 5 6 7 8 9 **Taping Condition** (6) After taping, check the mets 19-65 to Attale Dys weather 1900's factor X/2's measurement and condition of tape. 80±5mm 15 Tape the right side corrugated tape width tube (3 winds), width must be same as tape (19mm). tape width tape width

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