Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: Model Code/Part Number: 178D / 7N0129-7020 Customer: TRJ Document No.: WI-ENG-PDE-339C Purpose: Prototype Pr	_					WORK INST	RUCTION			Effe	ectivity Date:		January 06, 2	022	
PARTS: Al. All parts: Assy parts. Clamp 82711-32090 (W); Clamp 82711-34490 (B); Black tape [apcs]; While tape [1pc] NO. PROCESS NAME WORK PROCEDURE! ILLUSTRATION Table Lay-out Clamp 82711-32090 (W) Cla				Process Name/Title:		TAPING	ASSEMBLY PR	ROCESS					n/a		
PARTS: Al. All parts: Assy parts. Clamp 82711-32090 (W); Clamp 82711-34490 (B); Black tape [apcs]; While tape [1pc] NO. PROCESS NAME WORK PROCEDURE! ILLUSTRATION Table Lay-out Clamp 82711-32090 (W) Cla				Model Code/Part Number:	178D /					Doo	cument No.:		WI-ENG-PDE-3	339C	
PARTS: All parts: Assay parts; Clamp 82711-32090 (W); Clamp 82711-34490 (B); Black tape [4pcs.]; White tape [1pc.] NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION Table Lay-out Clamp 2711-34490 (B); Clamp 1711-34490 (B)				Purpose:			PRE-LAUNCH	MASSPR	0	Rev	ision No.:	1	Page No.:	1 of 6	
NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION Table Lay-out Table Lay-out Clamp 87711-36490 (W/) Clamp tray Clamp 87711-36490 (W/) Clamp tra													<u>'</u>	<u> </u>	
Table Lay-out Clamp 8271-3490 (N)/ Clamp tray Assy parts Revision Plastory Revision Plastory Revision Plastory Revision Plastory Approved by	PARTS:	<u>\(\)</u>	1. All pa	arts: Assy parts; Clamp 82711	I-52090 (W); Clamp 8	2711-3A540 (W); Clam	p 82711-34490 (B); Blad	ck tape [4pcs.]; Whit	e tape [1pc.]		JIG:	1. Clamp a	Clamp assembly jig		
Clamp 82711-34540 (W)/ Clamp tray Clamp 82711-3450 (B)/ Clamp tray Housekeeping I. Maintain and always is practice 5 s. 2. Personal frings on the workplace is prohibited. Keep it in your locker. Regular in your locker. Alert Level For any trouble, inform the Assembly Assistant Is Supervisor or Line IL leader for immediate I corrective action. I 1. No missing parts/hools 2. No excess parts/hools 2. No excess parts/hools 2. No excess parts/hools Revision History Revision History Revision History Into Clamp 1	N	0.	Р	ROCESS NAME		WORK PR	ROCEDURE/ ILLUS	STRATION			TOOLS/PPE		QUALITY POINTERS		
01/06/22 1 Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out. M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva A. Arañes J. Loterte C. Villanueva A. Arañes J. Loterte C. Villanueva A. Arañes	1	ı	P3	∕1\Table Lay-out	Clamp assembly jig	Clamp tray	Clamp 82: Cla	imp tray	Clamp tray	2 2 1 v	Safety Instruction e sure to wear requipersonal protective equipment during peration (gloves, fincots, etc.) Housekeeping 1. Maintain and alway practice 5's. Personal things on vorkplace is prohibit Keep it in your locked. Alert level For any trouble, inforthe Assembly Assistation Supervisor or Line Leader for immedia	the ted. 2. No excessorm ant testing the testing testi			
01/06/22 1 Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out. M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva A. Arañes				<u>l</u>		Revision History					Prepared by	Reviewed by	Approved by	Noted by	
Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date: September 20, 2021		1 0			rove work procedure/Illus	stration and quality pointers	s; Additional Table Lay-out.					J. Loterte	Diff	And	
	Eff. Date	Rev. No			Details of C	hange				Noted		September 20, 2021			

	_				WORK INSTRUCT	ION				Effectivity Date:		January	06, 2022
		Process Name/Title:	TAPING ASSEMBLY PROPCESS									n/a	
		Model Code/Part Number:	178D	1	7N0129-7020	Custome		TR	\J	Document No.:		WI-ENG-P	DE-339C
		Purpose:	☐ PRC	TOTYPE		PRE-LAUI	NCH		MASSPRO	Revision No.:		1 Page No.:	2 of 6
										ı			
PARTS:	2. Clam	p 82711-52090 (W) [4pcs.] p 82711-3A540 (W) p 82711-34490 (B)			٨	4. Black 5. White	tape [4pcs.] tape	I			JIG	Clamp assembly	ig
NO.	F	PROCESS NAME		L	√ı work procei	OURE/I	LLUSTR	ATION		TOOLS/	PPE	QUALITY POINTERS	
2	P3	Clamp setting	1. Get 2 pcs. both hands using both h 2. Get 2 pcs. both hands using both h 3. Get 1 pc. right hand the both hands.	then ins nands. of clammands. of clamphen inse	82711-3A5 ap 82711-52090 (W) using ert to clamp location 5 and 1 and 4 and 4 and 5 and 6	4. ha ha	2 3 Note: Please assembly to Get 1 pc. of c nd then inser nds. (See below)	e check the C avoid wrong clamp 82711 rt to clamp I low illustrati	lamp first before start of guse of clamp. -34490 (B) using right ocation 2 using both ion for clamp setting) R mitially attach to nands.	n/a		1. No wrong use of 2. No wrong use of 3. No damaged clam 4. No wvrong clamp	under clamp parts tape

				V	WORK INSTRU	JCTION			Effectivity Date:			January (06. 2022
		Process Name/Title:				SSEMBLY PR	Validity Date:		n/a				
		Model Code/Part Number:	178D	/ 7	N0129-7020	Customer:	Document No.:		WI-ENG-PDE-339C				
		Purpose:	☐ PF	ROTOTYPE		PRE-LAUNCH		MASSPRO	Revision No.:		1	Page No.:	3 of 6
	1								I				
PARTS:	1. Assy 2. Black			٨						JIG	1. Clam	ıp assembly j	ig
NO.	Р	ROCESS NAME		/1	WORK PRO	CEDURE/ ILLU	STRATION		TOOLS	OOLS/PPE		UALITY F	OINTERS
3	P3	CHECKER 1 Clamp assembly		1. Get the as First, set the continuity ch the checker of the PCB with of location 1 2. Check if al encountered walt for fur 3. Hold the t both hands.	assy parts and set into a connector 6188-006 hecking. Second, set fixture for continuity hin the stopper then a was ON. All LED light for Powed a abnormality, STOP rther instruction then tape on clamp location.	COLOR SENSON WHITE TAPE OF THE CONTROL OF THE CONTR	re for correct setting hen pull the checker 451 (W) to Checker o set the harness in o. Continue if the sec 21 & Wire2 was ON. LL the attention of tis. s of tape then cut th	r fixture for 2 then pull jig. Last, set quence light If he leader.	n/a		1. No w 2. No w 3. No d	rrong use of prong use of tamaged clamprong clamp prong clamp clamp prong clamp prong clamp prong clamp prong clamp clam	parts ape

			WORK INSTRU	JCTION		Effectivity Date:			January 0	6, 2022	
		Process Name/Title:	TAPING A	Validity Date:	/alidity Date:		n/a				
		Model Code/Part Number:	178D / 7N0129-7020	Customer:	Document No.:	cument No.:		WI-ENG-PDE-339C			
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		1 F	Page No.:	4 of 6	
	1	<u> </u>						1			
PARTS:	1. Assy 2. Black		٨				JIG	1. Clamp	assembly ji	g	
NO.	F	PROCESS NAME	∕₁ \ WORK PRO	CEDURE/ ILLU	JSTRATION	TOOLS/	PPE	QU	QUALITY POINTERS		
3	P3	CONNECTOR SETTING CHECKER 1 Clamp assembly	4. Initially tighten the band clamp on clamp I using both hands. 5. Get the bando gun using right hand then clamp on location 2 using both hands. Press button after cut. Continue the process if secon clamp location 3 was ON. BANDO G PERPENDICU	cut the band the SW quence light GUN LARITY NG OK NG F band clamp on the size of cube.		n/a		1. No wro 2. No wro 3. No dam	Make sure nor r jig and PCB	arts ape o	

				WORK INSTRUCTION	N		Effectivity Date:		January	06, 2022
		Process Name/Title:		TAPING ASSEM	Validity Date:		n/a			
	Model Code/Part Number:		178D / 7	7N0129-7020 Cu	Document No.:		WI-ENG-PDE-339C			
		Purpose:	PROTOTYPE	PR'	E-LAUNCH	MASSPRO	Revision No.:		1 Page No.:	5 of 6
		<u> </u>								
PARTS:	1. Assy 2. Black		۸	3. ¹		JIG	1. Clamp assembly	Clamp assembly jig		
NO.	F	PROCESS NAME		$_{f 1}$ WORK PROCEDUF	RE/ILLUSTRATION		TOOLS/	PPE	QUALITY	POINTERS
3	P3	CONNECTOR SETTING CHECKER 1 Clamp assembly (Continuation)	6. Hold the tape on cla windings of tape then hands. Color sensor lig detects White tape. Pr taping. Continue the pi clamp location 4 was C	amp location 3, make 3 cut the tape using both ght will beep/buzz if sensor cress the SW button after process if sequence light on	7. Hold the tape on clamp lowindings of tape then cut thands. Press the SW buttor Continue the process if sequence to the sequence of the sequ	ocation 4, make 3 the tape using both n after taping. uence light on clamp location 6, make 3 the tape using both	n/a		Note: Make sure stopper jig and h	parts tape mp

	WORK INSTRUCTION Effectivity Date:												January (06, 2022
		Process Name/Title:			TAPIN	G ASS	SEMBLY P	ROPCESS		Validity Date:		n/a		
		Model Code/Part Number:	178D	1	7N0129-7	020	Customer:	7	īRJ	Document No.:			WI-ENG-P	DE-339C
		Purpose:	PF	ROTOTYPE			PRE-LAUNCH		MASSPRO	Revision No.:		1	Page No.:	6 of 6
										L	1	1		
PARTS:	n/a										JIG	n/a		
NO.	Р	ROCESS NAME			WORK	PROCE	DURE/ ILLI	JSTRATION		TOOLS	/PPE	QUALITY POINTERS		
		/1	1. Check	the conne	ctor lock		the presence of ent and taping co		3. Check the Y-Taping con	ndition.				
4		Visual/ By two's inspection		v	0-2 1	m di	Using a steel rule easurement is wi mension (0~2mm cceed the maximu	thin the required) and should not	5. Compare to N	er to GL-PRO-ASY-0	007 for By	D. Mari	MASTER	SAMPLE
5	P3	Measurement	0~5mm 116±5m	am I	104±5mm 0~5mm 111±3mm	6 7 8	50±5mm	Note:	e calibrated/verified measure ne measurement. 60±3mm 94±3mm	ing tape when			OR HATSUN OWARII	