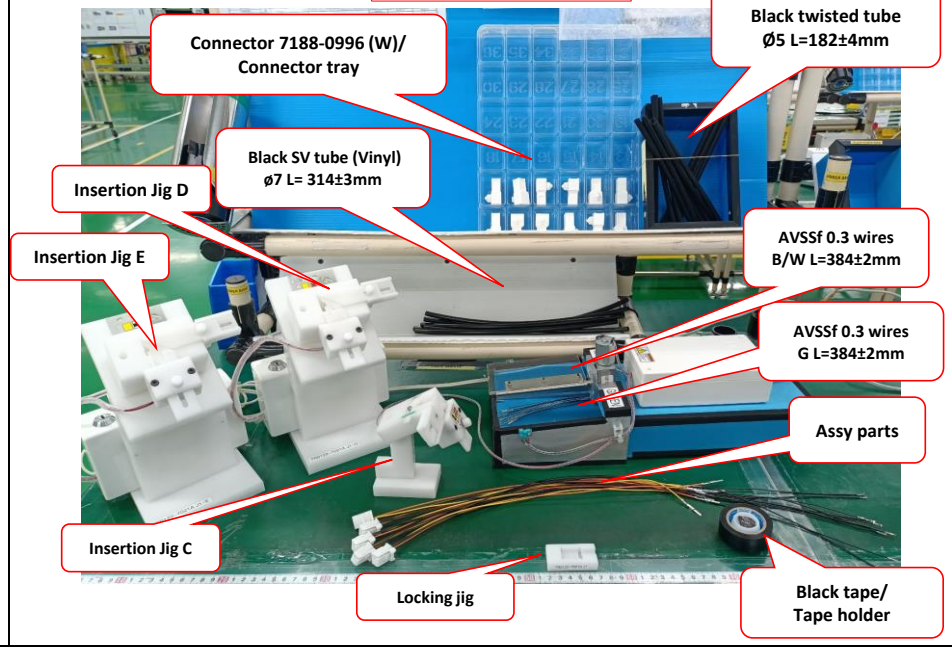
	WORK INSTRUCTION			Effectivity Date:	May 17, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number: 920B / 7R0122-7021A	Customer:	TRMX	Document No.:	WI-ENG-PDE-656A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.:	1 of 10

PARTS:	1. All parts: Assy parts: AVSSf 0.3 wires Y-OR L=384±2mm; Connector 7188-0996 (W); Black twisted tube Ø5 L=182±4mm; Black SV tube (Vinyl) ø7 L= 314±3mm; Black tape	JIG:	1. Insertion jig with adjustable stand 2. Insertion jig with switch cover 3. Tape cutter 4. Locking 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 prescribed 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.	***Document reference/s:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** ***2. Refer to WI-ENG-PDE-674 for 7R0122-7021A Offline Assembly Process*** 1 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
05/17/23	1	Change document purpose from pre-launch to masspro. Inclusion of table lay-out. Transfer process to Offline assembly process and P2.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes
03/23/23	0	Initial issue.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	J. Loterte	C. Villanueva	A. Arañes
Eff. Date:	March 23, 2023		

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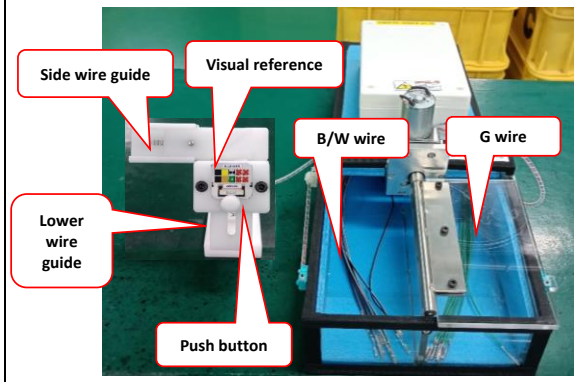
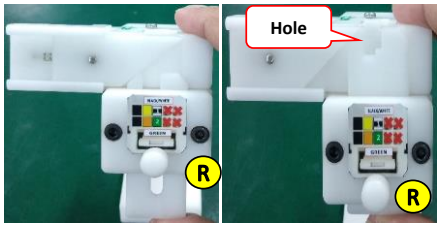
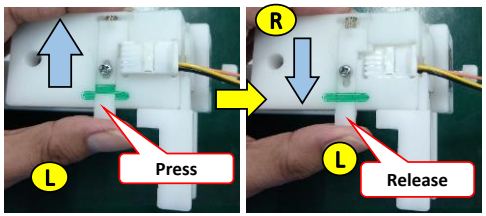
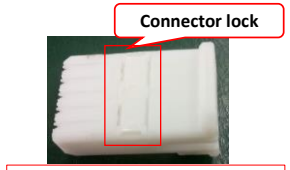
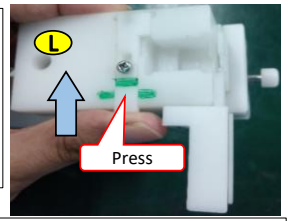
	Model Code/Part Number:	920B / 7R0122-7021A	Customer: TRMX	Document No.:	WI-ENG-PDE-656A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 2 of 10

PARTS:	1. Assy parts	JIG	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 6098-3909 (W)	**Insertion jig with switch cover**   1. Push the lower wire guide using left hand, the slot for **B/W wire** will be opened.  2. Press the lock of insertion jig using left thumb. 3. Insert the connector **6098-3909 (W)** into jig using right hand and release the lock.  **Connector Orientation** **Insertion jig Orientation**  	n/a	***Important reminders/Note/s:*** ***1. Follow the connector orientation*** ***2. Cannot insert the inverted connector.*** 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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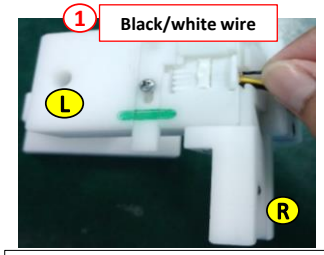
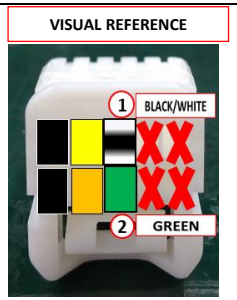
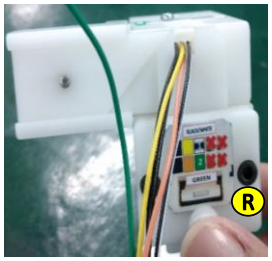
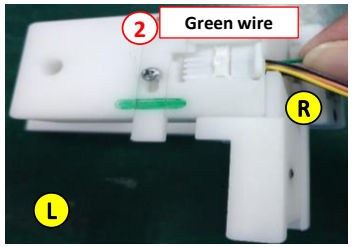
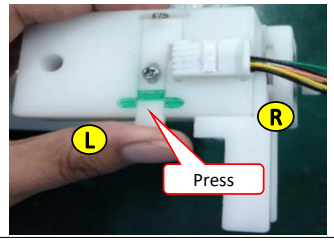
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 3 of 10

PARTS:	1. Assy parts 2. AVSSf 0.3 wires G-B/W L=384±2mm	JIG	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Connector 6098-3909 (W)	 1. Get the **Black/white wire** using right hand then insert to terminal **slot 1** using right hand.   2. Press the button using left hand, the slot for **Green wire** will be opened.  3. Get the **Green wire** using right hand then insert to terminal **slot 2** using right hand.  4. After insertion, press the lock guide 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 ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***Document references:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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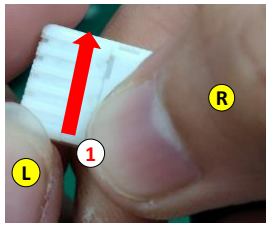
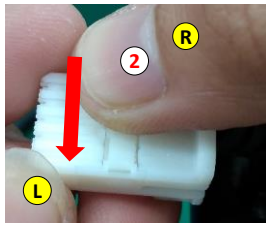
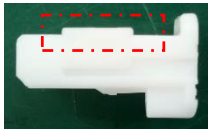
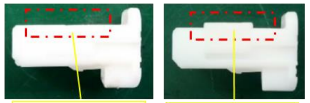
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 4 of 10

PARTS:	1. Assy parts 2. Black SV tube (Vinyl) Ø7 L=314±3mm	JIG	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Connector Lock	 1. Put the connector into locking jig using right hand then press **2x** using both hands. Touch the connector lock to confirm if properly locked.   2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.  Before Pressing After Pressing	LOCKING JIG 	***Important reminders/Note/s:*** ***1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR*** ***Document reference/s:*** ***1. Refer to WI-PRO-KIT-001 Proper locking and checking of connector lock*** 1. Use the provided locking jig per model 2. No unlock/half-locked connector CONNECTOR LOCK CONDITION GOOD NG  Fully Locked UnLocked
5		Wire insertion to Black SV tube (Vinyl) Ø7 L=314±3mm	 1. Get the Black SV tube (Viny) Ø7 L=314±3mm using right hand then insert the **all wires** using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal

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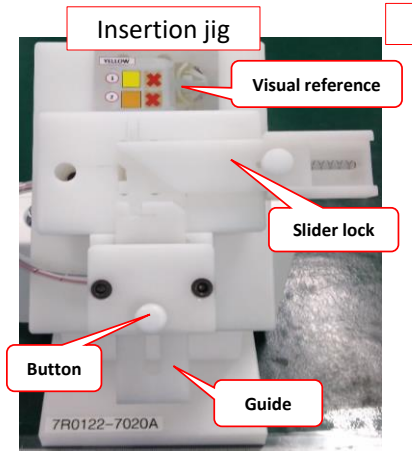
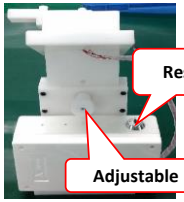
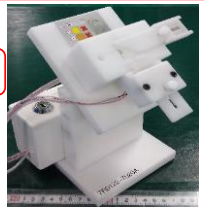
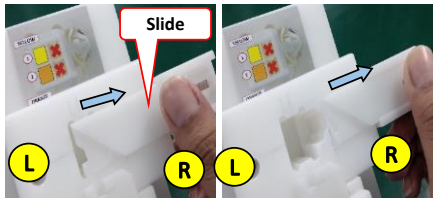
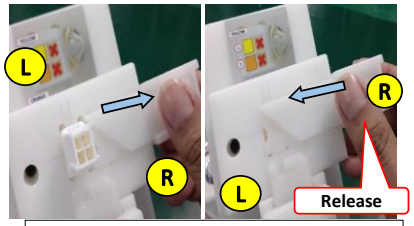
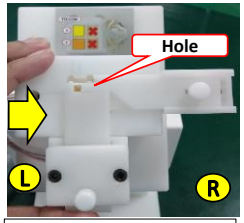
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 5 of 10

PARTS:	1. Connector 7188-0996 (W)	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Connector setting to insertion jig 7188-0996 (W)	 Connector Orientation    1. Slide the slide lock using right thumb.  2. Insert the connector **7188-0996 (W)** into jig using left hand and release the side lock.  3. Push the guide using left hand. The slot for **Yellow wire** will be opened.	n/a	***Important reminders/Note/s:*** ***1. Cannot insert the inverted connector.*** 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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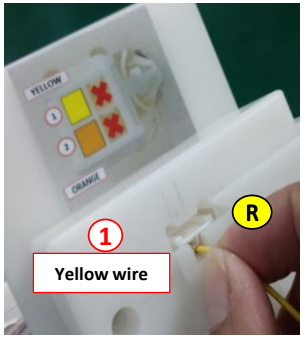
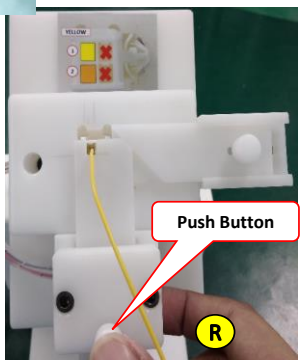
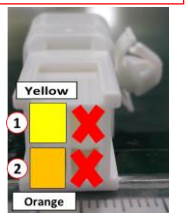
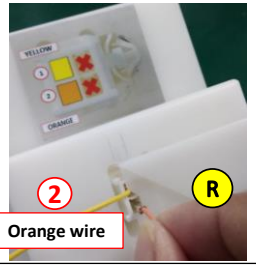
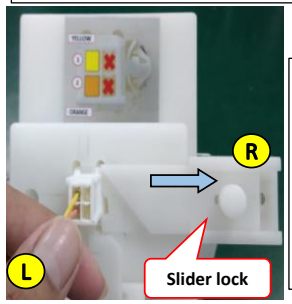
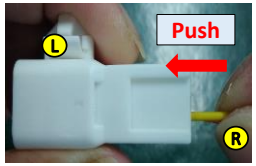
PARTS:	1. Assy parts	JIG	1. Insertion jig with controller

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire insertion to connector 7188-0996 (W)	Wire facing  1. Get the **Yellow wire** then insert to terminal slot **1** using right hand. Conduct **Pull-Push-Pull-Push** after insertion.  2. Press the button using left hand. The slot for **Orange wire** will be opened. VISUAL REFERENCE   3. Get the **Orange wire** then insert to terminal slot **2** using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. **GO** sound will be heard.  4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.  5. After removing the connector from jig, conduct **Pushing (1x)** of **Y wire** using right hand to confirm that wire is fully inserted. Repeat the process for **OR wire.**	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.*** ***4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.*** ***5. Conduct Pushing of wires after removing the connector from jig.*** ***6. Pushing of wires will be done one by one of every inserted wires*** ***Document references:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***

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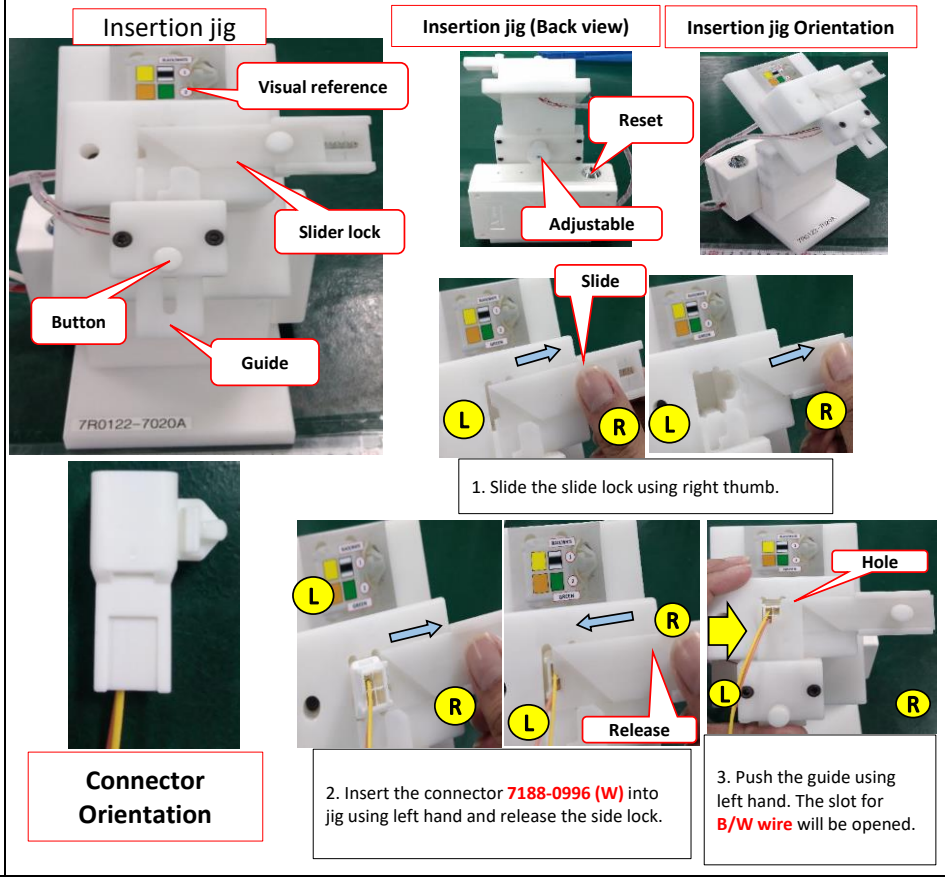
PARTS:	1. Assy parts	JIG	1. Insertion jig with controller

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Connector setting to insertion jig 7188-0996 (W)	 1. Slide the slide lock using right thumb. 2. Insert the connector **7188-0996 (W)** into jig using left hand and release the side lock. 3. Push the guide using left hand. The slot for **B/W wire** will be opened.	n/a	***Important reminders/Note/s:*** ***1. Cannot insert the inverted connector.*** 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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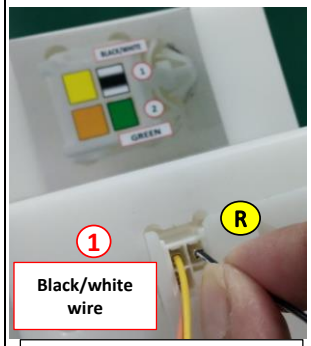
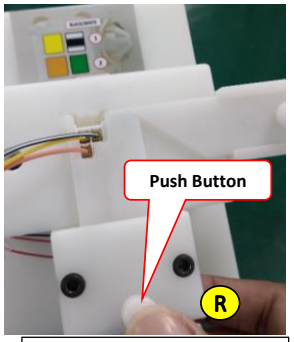
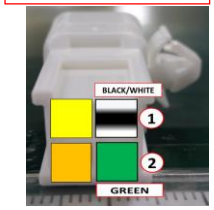
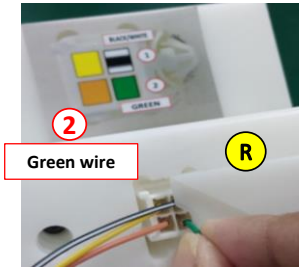
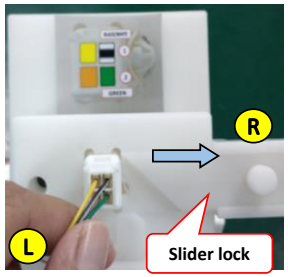
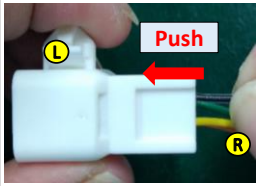
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 8 of 10

PARTS:	1. Assy parts	JIG	1. Insertion jig with controller

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to connector 7188-0996 (W)	Wire facing  1. Get the **Black/white wire** then insert to terminal slot **1** using right hand. Conduct **Pull-Push-Pull-Push** after insertion.  2. Press the button using left hand. The slot for **Green wire** will be opened. VISUAL REFERENCE   3. Get the **Green wire** then insert to terminal slot **2** using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. **GO** sound will be heard.  4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.  5. After removing the connector from jig, conduct **Pushing (1x)** of **B/W wire** using right hand to confirm that wire is fully inserted. Repeat the process for **G wire.**	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.*** ***4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.*** ***5. Conduct Pushing of wires after removing the connector from jig.*** ***6. Pushing of wires will be done one by one of every inserted wires*** ***Document references:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***

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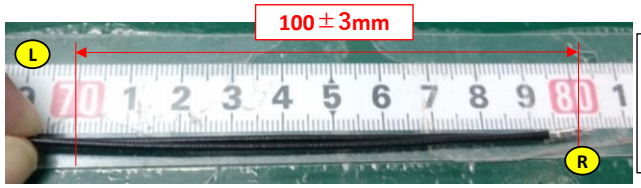
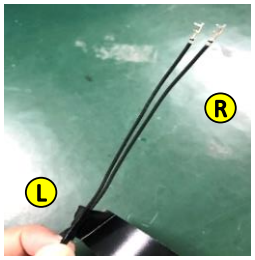
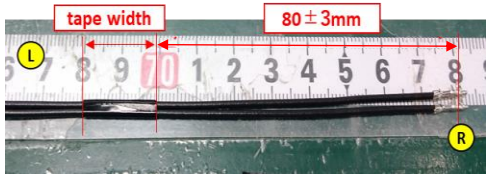
	WORK INSTRUCTION			Effectivity Date:	May 17, 2023	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Part Number: 920B / 7R0122-7021A	Customer: TRMX		Document No.:	WI-ENG-PDE-656A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 9 of 10

PARTS:	1. Assy parts 2. Black tape	3. Black twisted tube Ø5 L=182±4mm	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	Spot taping 1	 1. Hold the wires using left hand and measure from wire up to terminal pointed tip **100±3mm.**  2. Get the **Black tape** and start taping on the Black wires. Conduct **2 windings** of tape before cutting using both hands.  3. After taping, check the measurement and taping condition.	MEASURING TAPE 	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 ***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.***
11		Wire insertion to Black twisted tube Ø5 L=182±4mm	 1. Get the Black twisted tube **Ø5 L=182±4mm** using right hand then insert the **B-B wire** using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal

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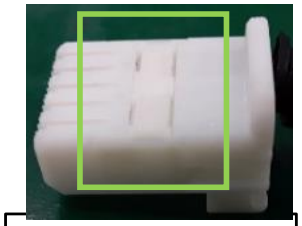
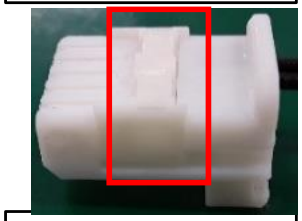
PARTS:	1. Assy parts	**JIG**	n/a

QUALITY CHECKPOINTS

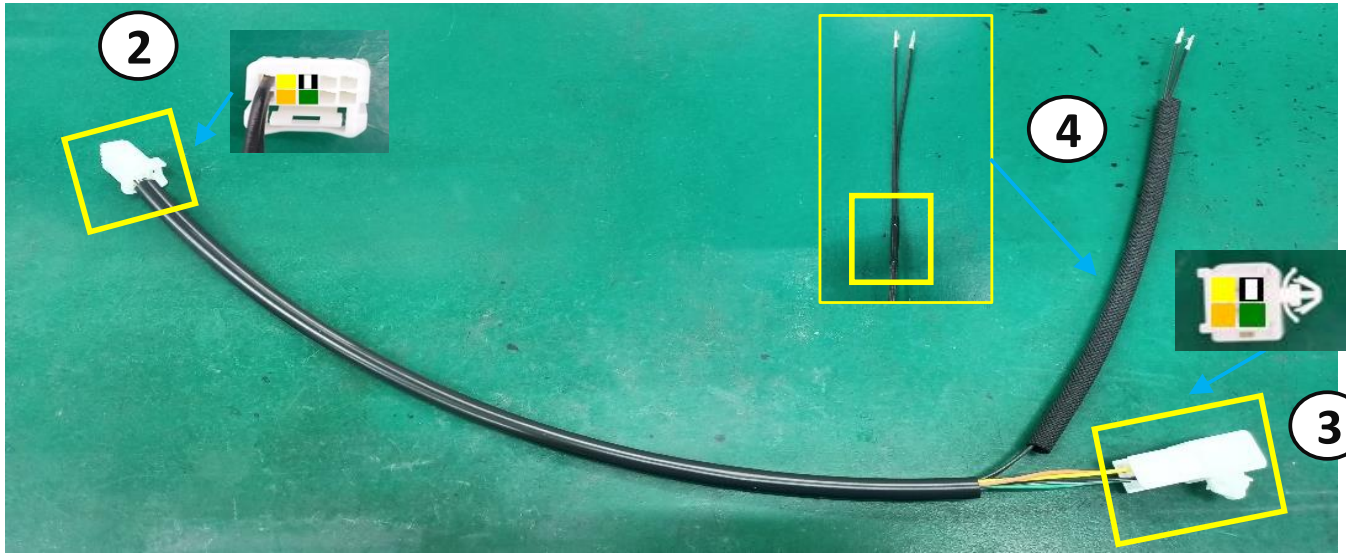
P1	7R0122-7021A

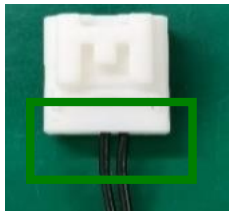


GOOD

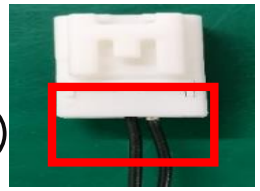


NO GOOD





GOOD



NO GOOD

① No Unlock/Halflocked Connector

②③ No Wrong Insert

④ No Missing Spot tape

⑤ No Terminal Backing Out

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