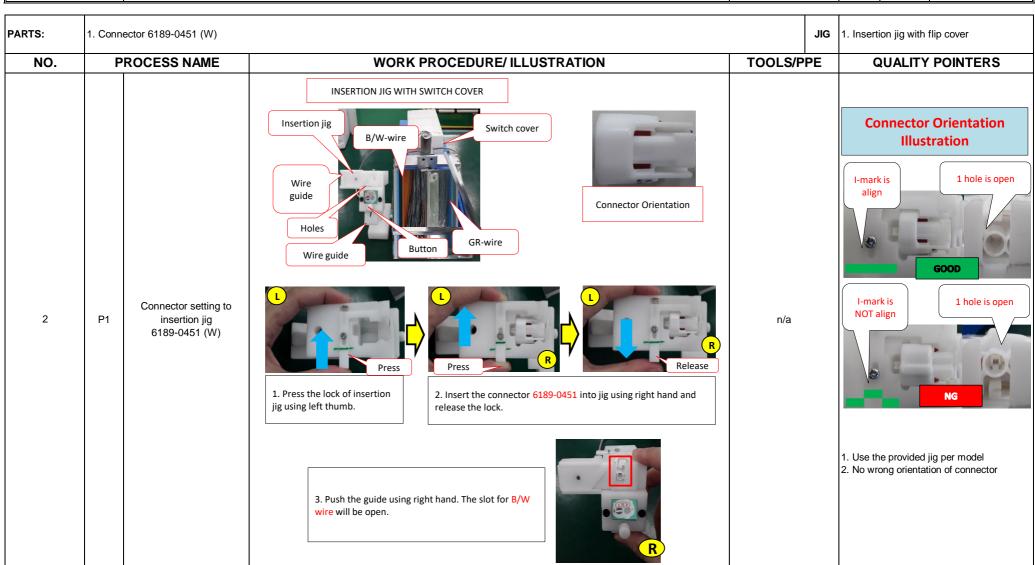
			WORK INSTRUCTION								Effectivity Date:		November 12, 2021			
			Process Name/Title:		TAPI	NG AS	SEMBLY PRO	OCESS		Val	idity Date:		n/a			
			Model Code/Part Number:	150B	/ <u>3</u> 7L0060-7	022	Customer:	TR	QSS	Do	cument No.:		į	WI-ENG-PDE-184A		
			Purpose:	☐ PR	ОТОТҮРЕ		PRE-LAUNCH	MASS	SPRO	Rev	vision No.:		3	Page No.:	1 of 5	
		ı														
PARTS:	<u></u>	1. Assy L=548±	parts; Black corrugated tube 3mm;	φ5 L=352±3m	ım (No slit); Black Sunp	rene tube	φ5 L=101±3mm TVS	SSf 0.3 B/W wire L=	548±3mm; T	VSSf 0.3 GR	wire	JIG: 2	 Insertion jig Terminal co Locking jig 	ver jig		
N	Ο.	Р	ROCESS NAME		WORK	PROCI	EDURE/ ILLUS	TRATION			TOOLS	/PPE	QUALITY POINTERS			
1		P1	Table Lay-out	Connector 6189-0451 (W) TVSSf 0.3 I L=548± Insertion ji flip cov	TVSSf 0.3 GR wire L=548±3mm B/W wire :3mm	Locking jig	Table Lay-ou	Black Sunprer \$\phi S L=101±3		1 F t	Safety Inst Be sure to prescribed protective enduring oper (gloves, fing etc.) Housekeer Maintain ar practice 2. Personal the workpl prohibited. K your lock for any troub he Assembly Supervisor Leader for im corrective	eping d always 5's. hings on ace is eep it in ker. evel e, inform Assistant or Line hersonal ladiupment ladiu				
Revision History									Prepared by:	Checked b	y: Approved by:	Noted by:				
11/12/21 05/18/21	3	Change part number from 7L0060-7021 to 7L0060-7022 due to additional clamp (82711-60640 (B) (Refer to WI-ENG-PDE-184B). Improve work procedure and illustration. Additional table lay-out, checkpoint in checking of wire tolerance. Remove validity date. Add tape quantity.				K. Doria D.Castillo	J. Loterte	C. Villanueva		Dojla K Doria	J. Lowert	e C. Villanueva	A.Arañes			
Eff. Date			and the granting		tails of Change			Revise	Check	Approve	Noted	Established Da		October 17, 2018	/ A.AHAHICO	
- 1	·	•			*			•	•		•			·		



		WORK INSTRU	Effectivity Date:	er 12, 2021				
Process Name/Title:	TAPING A	Validity Date:	n/a					
Model Code/Part Number:	150B	/ <u>3</u> 7L0060-7022	Customer:	TRQSS	Document No.:		WI-ENG	-PDE-184A
Purpose:	urpose: PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	3	Page No.:	2 of 5

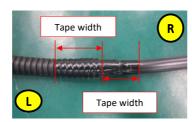


			WORK INST	RUCTION		Effectivity Date:	November 12, 2021
		Process Name/Title:	TAPING	S ASSEMBLY PRO	OCESS	Validity Date:	n/a
		Model Code/Part Number:	150B // ₃ \ 7L0060-702	22 Customer:	TRQSS	Document No.:	WI-ENG-PDE-184A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.: 3 of 5
		1 -					
PARTS:	\	Sf 0.3 Wires GR L=548±3mr	n; B/W L=548±3mm			JIG	Insertion jig Locking jig
NO.	P	PROCESS NAME	WORK PF	ROCEDURE/ ILLUS	TRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Connector 6189-0451 (W)	1. Get the B/W wire then insert to terminal slot 1 using right hand. Gray 3. Get the GR wire then insert to terminal slot 2 using right hand.	4. After insertion, push	After insertion of B/W wire press the utton using right hand. The slot for GR ire will be open. L R the lock using left thumb and then ntly pull out the connector from jig using	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
4		Connector Lock	Put the connector into locking jig using right hand then press to lock 2x. Check the connector lock to confirm if properly locked	BEFORE PRESSING AFTER PRESSING	Check the double lock deformation	Locking jig	NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK. 1. Must be fully inserted 2. No double lock deformation 3.No Unlock/Half-locked of connector

TAPING ASSEMBLY PROCESS Model Code/Part Number: 150 B				WORK INSTRU	Effectivity Date:	November 12, 2021						
PARTS: 1. Black Corrugated tube \$6, L= 362±3mm (no sit) 2. Black Lape Work PROCEDURE/ ILLUSTRATION TOOLS/PPE Wire insertion to corrugated tube \$6, L=362±3mm (no sit) 1. Cet the terminal cover jig using right hand then insert the GR-8/W wires using left hand. See the first proceed to using see the corrugated tube up to corrugated using left hand. PI Taping 1 COT to wire near cornector COT to wire near cornector 1. Nollip out tape 2. No deformed terminal cover jig using right hand. Note: (1. Nollip out tape 2. No tape peeling 3. No lissous tape 3. No missuing tape 4. No missuing tape 5. No missuing tape 6. No missuing tape 6. No missuing tape 7. No missuing tape 8. Note: 8. No missuing tape 8. Note: 8. No missuing tape 8. Note: 8.			Process Name/Title:	TAPING A	SSEMBLY PROCE	SS	Validity Date:		n/a			
PARTS: 1. Black Corrugated tube \$6, L= 352±3mm (no slit) 3. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. No wrong use of corrugated tube \$6, L= 352±3mm (no slit) 2. Get the Black corrugated tube (no slit) \$ 1. No wrong use of corrugated tube \$6, L= 352±3mm (no slit) 2. Get the Black corrugated tube (no slit) \$ 1. No wrong use of corrugated tube \$2, No deformed torminal tube \$2, No deformed torminal tube \$2, No deformed torminal cover jig slit hand. P1 Taping 1 COT to wire near corrugated using left hand then proceed to taping. No less registed to the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed tube up to connector \$2, 3, and the proceed to taping. No less registed to taping the hand did the proceed to taping. No less registed to the proceed to taping. No less registed the proceed to taping. No less registed the proceed to taping. No less registed to taping the hand did the proceed to taping. No less registed to taping the hand did the proceed tor			Model Code/Part Number:	150B / <u>/</u> 3\ 7L0060-7022	Customer:	TRQSS	Document No.:			WI-ENG-P	DE-184A	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. No wrong use of corrugated tube (as skit) 45 Lus 52.3 mm (no skit) 1. No wrong use of corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand. 2. No deformed terminal cover jig using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using rig			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	4 of 5	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. No wrong use of corrugated tube (as skit) 45 Lus 52.3 mm (no skit) 1. No wrong use of corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand. 2. No deformed terminal cover jig using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using right hand then insert the corrugated tube (as skit) 45 Lus 52.3 mm using rig							· 		· 			
Wire insertion to corrugated tube (no sit) 1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand. 2. Get the Black corrugated tube (no sit) 65 (1-352±3mm using right hand then insert the GR-B/W wires using left hand. 3. After insertion, remove the terminal cover jig using right hand. 3. After insertion, remove the terminal cover jig using right hand. 4. No deformed terminal cover jig using right hand. 4. No deformed terminal cover jig using right hand. 5. No deformed terminal cover jig using right hand. 6. No deformed terminal cover jig using right hand. 7. No wrong use of corrugated tube 2. No deformed terminal cover jig using right hand. 8. No deformed terminal cover jig using right hand. 9. No deformed terminal cover jig using right hand. 1. No flip out tape 2. No tape peeping 3. No loose tape 3. No loose tape 4. No terminal cover jig using deft hand. Get Black tape using right hand and start in the measurement and taping. Note: Please use calibrated/verified measurement and taping to be when getting the measurement and taping the start the measurement and taping the measurement and taping the start the measurement and taping the measurement and taping the start the measurement and taping the measurement and taping the start the measurement and taping the measurement and taping the start the measurement and taping the measurement and taping the start the measurement and taping the measurement and taping the taping the measurement and tap	PARTS:			2±3mm (no slit)	3. Assy parts			JIG	1. Termi	nal cover jig		
Wire insertion to corrugated tube \$\frac{1}{4}\$ L=352±3mm (no siti) 1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand. 2. Get the Black corrugated tube (no slit) \$\frac{1}{4}\$ St=352±3mm using right hand then insert the GR-B/W wires using left hand. 2. Measure the corrugated tube up to connector 25±3mm cover jig using right hand and then insert the corrugated tube up to connector 25±3mm left hand then proceed to taping. No lose tape PRO-AS7-001 for taping procedure. 1. No flip out tape 2. No deformed terminal cover jig using right hand hand. 2. Measure the corrugated tube up to connector 25±3mm left hand then proceed to taping. No lose tape 1. No flip out tape 2. No tape peeling 3. No lose tape 4. No wrong use of taping 3. No lose tape 4. No wrong use of taping 1. No flip out tape 2. No deformed terminal cover jig using right hand and taping to connector (includes rubber seal) 1. Hold the corrugated using left hand. Get Black tape using right hand and start using tape when getting the measurement and taping the peeling thand and start the corrugated using left hand and start the measurement and taping the deformation to connector (includes rubber seal) 2. Measuring tape 1. No flip out tape 2. No flip out tape 2. No flip out tape 2. No worng use of tape 3. No long than the procedure. 3. After taping, check the measurement and taping the deformation to the peeling thand and start the corrugated using left hand. 3. After taping, check the measurement and taping the left hand the procedure. 4. Note: Please use calibrated/verified measurement and taping the left hand the procedure. 5. No missing tape 4. No worng use of tape 3. After taping, check the measurement and taping the left hand the procedure. 6. No missing tape 4. No worng use of tape 3. No worng tape 4.	NO.	Р	ROCESS NAME	WORK PRO	CEDURE/ ILLUSTRA	TION	TOOLS/I	PPE	QI	UALITY P	OINTERS	
Taping 1 COT to wire near connector R 1. Hold the corrugated using left hand. Get Black tape using right hand and start 1. Hold the corrugated using left hand and start 1. Hold the corrugated using left hand and start 1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape 1. Hold the corrugated using left hand. Get Black tape using right hand and start 1. Hold the corrugated using left hand and start with the corrugated using left hand and start when getting the measurement and taping the left hand and start when getting the left hand hand hand hand hand hand hand hand	5		corrugated tube φ5 L=352±3mm	1. Get the terminal cover jig using right hand then insert the GR-B/W wires using	2. Get the BI. L=352±3mm GR-B/W wire 3. After insertion, r cover jig using righ	ack corrugated tube (no slit) ф5 using right hand then insert the us using left hand.	Terminal co	over jig				
	6	P1	COT to wire near	1. Hold the corrugated using left hand. Get Black tape using right hand and start 6	25±3mm	corrugated tube up to connector 25±3mm using left hand then proceed to taping. Note: Refer to WI-PRO-ASY-001 for taping procedure. Note: 0 - 5mm -> End tape up to connector (includes rubber seal) 3. After taping, check the measurement and taping	6789 (1)1234	5 6 7 8 9	2. No tap 3. No loo 4. No wro 5. No wro 6. No mis	e peeling se tape ong use of tal ong dimensic ssing tape use calibrat ring tape wi	ed/verified	

				TRUCTION G ASSEMBLY PRO		Effectivity Date:			November	
		Process Name/Title:	Validity Date:	1	n/a					
		Model Code/Part Number:	150B $/\sqrt{_3}$ 7L0060-70	Customer:	TRQSS	Document No.:			WI-ENG-P	DE-184A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	5 of 5
PARTS:	1. Black 2. Assy	•	·	ne tube ø5 L=101±3mm	RATION	TOOLS/I		N/A Q	UALITY F	POINTERS
7		Wire insertion to Black Sunprene tube ø5 L=101±3mm	L THE	N/A	N/A			No wrong use of parts		
8	P1	Taping 2 Black Corrugated tube to Black Sunprene tube	1. Hold the COT using left hand and fix t sunprene tube using right hand.	2. Hold the as Black tape and right hand.	ssy parts using left hand. Get the d start the taping process using refer to WI-PRO-ASY-001 for taping	Measuring	5 6 7 8 9	1. No fli 2. No ta 3. No lo 4. No w	e use calibra	then getting the

5. No wrong dimension6. No missingf tape



3. After taping, check the measurement and taping condition.

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