PROCESS Hamer Title: TAPING ASSEMBLY PROCESS Ovalidad Outer Number Outer Outer Number Outer Number Outer O							WORK INST	RUCTION			Effectivity Date:		April 24, 202	3
PARTS: 1. Assy parts; Clamp 8271-53090 (W); Clamp 8271-34540 (W);				Process Name/Title:			TAPING	ASSEMBLY PRO	CESS		Validity Date:		n/a	
PARTS: 1. Assy parts: Clamp 82711-32000 (W); Clamp 82711-34400 (B); Black tape (Spots) NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION Table Lay-out Clamp 82711-3450 (W) Clamp 82711-3450 (W) Clamp 82711-3450 (W) Clamp 82711-3450 (W) Clamp 124 Flore Exercised personal protective capingment to during operation (gloves, inger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prothered. Keep if in your locker. 2. No wrong use of tape Assy parts Revision History Revision History Revision History Procued by Procued by Approved b				Model Code/Part Number:	011B	1	7M0365-7021	Customer:	TRJ		Document No.:		WI-ENG-PDE-4	18C
NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION Table Lay-out Table Lay-out Clamp 8271.3456 (W/) Clamp tray Clamp 8271.3456 (W/) Clamp tray Thousekeeping 1. Maintain and always 2. No worming use of parts 3. No worming use of parts 3. No worming use of parts 3. No worming use of parts 4. No demong clamp 4. No demong clamp 5. No worming use of parts 6. No worming use of parts 7. No worming use of parts 8. No worming use of				Purpose:	PR	ROTOTYP	E	PRE-LAUNCH	MASSPRO		Revision No.:	3	Page No.:	1 of 9
NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION Table Lay-out Table Lay-out Clamp 8271.3456 (W/) Clamp tray Clamp 8271.3456 (W/) Clamp tray Thousekeeping 1. Maintain and always 2. No worming use of parts 3. No worming use of parts 3. No worming use of parts 3. No worming use of parts 4. No demong clamp 4. No demong clamp 5. No worming use of parts 6. No worming use of parts 7. No worming use of parts 8. No worming use of														
Table Lay-out P3 Table Lay-out Table Lay-out Table Lay-out Table Lay-out Clamp 82711-32590 (W) Clamp 12711-33490 (R) Clamp 82711-34590 (R) Nousekeeping 1. Maintain and always practice 5's 2. Personal things on the very practice 5's 3. Personal things on the very practice 5's 3. No wrong use of lamp 2. No wrong use of lamp 3. No wrong use of lamp 4. Across the very lamped clamp 5. No wrong use of lamp 6. Things on the very lamped clamp 6. No wrong use of lamp 7. No wrong use of lamp 8. No wrong	PARTS:		1. Assy	parts; Clamp 82711-52090 (V	V); Clamp 827	711-3A5	540 (W); Clamp 82711-3	4490 (B); Black tape [5pcs	1		JIG:	1. Clamp as	ssembly jig	
P3 Table Lay-out P3 Table Lay-out Clamp 82711-32490 (M) Clamp 82711-34490 (B) P1 P2 P2 P2 P3 P3 P3 P3 P3	NO	Ο.	F	PROCESS NAME			WORK PR	ROCEDURE/ ILLUST	RATION		TOOLS/PPE	: 0	QUALITY POIN	ITERS
04/24/23 3 Inclusion of quality checkpoints J. Loterte C. Villanueva A. Arañes n/a 11/07/22 2 Improve quality pointers, notes reference in process no.2,3,4 and 5 as document improvement. Work procedure and illustration in process no.4 - visual/by two's inspection M. Catapang J. Loterte C. Villanueva A. Arañes 03/31/22 1 Removal of spot taping process in clamp assembly on clamp location 2 M. Catapang J. Loterte C. Villanueva A. Arañes 02/22/22 0 Initial issue M. Catapang J. Loterte C. Villanueva A. Arañes	1		P3	Table Lay-out		82711-5 Clamp to	2090 (W)/ray		Clamp tray Clamp 82711-	IBC 1	Be sure to wear prescribed person protective equipme during operation (glo finger cots, etc.) Housekeeping 1. Maintain and alway practice 5's. 2. Personal things on workplace is prohibit Keep it in your locket all the Assembly Assists Supervisor or Line Let for immediate correct action.	al ent oves, in the ted. 1. No dama er. 2. No wrong orm in ant ader	use of parts	
11/07/22 2 Improve quality pointers, notes reference in process no.2,3,4 and 5 as document improvement. Work procedure and illustration in process no.4 - visual/by two's inspection M. Catapang J. Loterte C. Villanueva A. Arañes A. Arañes O3/31/22 1 Removal of spot taping process in clamp assembly on clamp location 2 M. Catapang J. Loterte C. Villanueva A. Arañes J. Loterte C. Villanueva A. Arañes J. Loterte J. Loterte C. Villanueva A. Arañes J. Loterte J. Loterte C. Villanueva J. Loterte J. Lot							Revision History				Prepared by	Reviewed by	Approved by	Noted by
11/07/22 2 Improve quality pointers, notes reference in process no.2,3,4 and 5 as document improvement. Work procedure and illustration in process no.4 - visual/by two's inspection M. Catapang J. Loterte C. Villanueva A. Arañes O2/22/22 0 Initial issue M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva A. Arañes J. Loterte V. Villanueva A. Arañes	04/24/23	3	Inclusion	of quality checkpoints					J. Loterte C. Villanueva	A. Arañes n/	a			
02/22/22 0 Initial issue M. Catapang J. Loterte C. Villanueva A. Arañes J. Loterte C. Villanueva A. Arañes n/a	11/07/22	2				2,3,4 and	d 5 as document improvem	nent. Work procedure and	M. Catapang J. Loterte C	C. Villanueva A. Ara	nñes	1/1.:11	Alar	
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Eff. Date Rev. No Details of Change Revised Checked Approved Noted Est. Date: February 22, 2022			Initial issu	е									/ A. Arañes	n/a
	Eff. Date	Rev. No			De	tails of C	Change		Revised Checked A	Approved Not	ed Est. Date:	February 22, 2022		

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		Process Name/Title:		TAPING ASSEMBLY PROCI	ESS	Validity Date:	n/a
		Model Code/Part Number:	011B /	7M0365-7021 Customer:	TRJ	Document No.:	WI-ENG-PDE-418C
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	1	I					
PARTS:	1. Clam 2. Clam	p 82711-52090 (W) [4pcs.] p 82711-3A540 (W)		3. Clamp 82711-34490 (B) 4. Black tape [5pcs.]		JIG	1. Clamp assembly jig
NO.	F	PROCESS NAME		WORK PROCEDURE/ ILLUSTRA	TION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting	1. Get 2pcs. set to location 2. Get 2pcs. set to location 3. Get 1pc. co	2090 (W) 82711-3A540 (W) of clamp 82711-52090 (W) using both hands and on 1 and 2 using both hands. of clamp 82711-52090 (W) using both hands and on 4 and 5 using both hands.	82711-34490 (B) 4. Get 1pc. of clamp 82711-34490 (and set to location 6 using both half. 5. Initially attach Black tape on clarand 5 using both hands.	(B) using right hand nds.	Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp. 1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape CLAMP ILLUSTRATION GOOD RETTI-52090 (W) BAND CLAMP ILLUSTRATION GOOD NG 82711-12A80 (W) BAND CLAMP ILLUSTRATION GOOD NG 82711-16830 (B)

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		Process Name/Title:			TAPING AS	SSEMBLY PR	OCESS	Validity Date:			n/a	a	
		Model Code/Part Number:	0111	B /	7M0365-7021	Customer:	TRJ	Document No.:			WI-ENG-P	DE-418C	
		Purpose:		PROTOTYP	E	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	3 of 9	
											<u> </u>		
PARTS:	1. Assy 2. Black								JIG	1. Clamp	1. Clamp assembly jig		
NO.	F	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION					PPE	QUALITY POINTERS		OINTERS	
3	P3	Clamp Assembly		Checker 1 and 6189-0451 (With the stopper to 2. Check if all CLAMP ON wimmediately 0	d then pull the checker fix <mark>V)</mark> to <mark>Checker 2</mark> and then _l	ture for continuity che- bull the checker fixture of Continue the process wire1, wire2 and normality, STOP and leader. WAIT for	e correct setting). First, set the cking. Continue to set the Y-ta of for continuity checking. Last, if sequence light in location 1 3. Hold the tape on clamp hands. Make 3 windings the	e connector 6188-0066 (GR) to ping in Hook. Then, set the connect the G-B/W wires together wire was ON. location 1 and start taping using then cut the tape. Press the SW but process if sequence light on locations.	ector thin both utton	1. No loc 2 .No da 3. No mi 4. No mi	lake sure no per and tern	nent of clamp p	

WORK INSTRUCTION Effectivity Date:								April 24	, 2023			
		Process Name/Title:			TAPING AS	SEMBLY PR	ROCESS	Validity Date:			n/a	a
		Model Code/Part Number:	011B	1	7M0365-7021	Customer:	TRJ	Document No.:			WI-ENG-P	DE-418C
		Purpose:	Pr	ROTOTYPE	Ξ [PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	4 of 9
PARTS:	1. Assy 2. Black								JIG	1. Clamp	assembly ji	ig
NO.	Р	ROCESS NAME			WORK PROCE	EDURE/ ILLU:	STRATION	TOOLS/	PPE	Ql	JALITY P	POINTERS
3	P3	Clamp Assembly (Continuation)	both SW light	Hold the ta h hands. M button aft t on location Hold the ta h hands. M button aft	CHECKER 2 CHECKER 2 CHECKER 1 The pe on clamp location 2 and Alake 3 windings then cut the ter taping. Continue the proof on 3 was ON. The pe on clamp location 4 and Alake 3 windings then cut the ter taping. Continue the proof on 5 was ON.	ne tape. Press the occess if sequence start taping using the tape. Press the		and start taping using the tape. Press the process if sequence and start taping using the tape. Press the tape.	ag e e e e e e e e e e e e e e e e e e e	1. No loo 2. No da 3. No mis 4. No mis	ake sure no per and tern	ent of clamp

			WOF	RK INSTRUCTION		Effectivity Date:	April 24, 2023
		Process Name/Title:	T	TAPING ASSEMBLY P	ROCESS	Validity Date:	n/a
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		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.: 5 of 9
PARTS:	1. Assy	parts				JIG	1. Clamp assembly jig
NO.	F	PROCESS NAME	W	ORK PROCEDURE/ ILLU	TOOLS/PPE	QUALITY POINTERS	
3	P3	Connector settin Clamp Assembly (Continuation)	CHECKER 2	nt hand then cut the band hands. Press the SW	BANDO GUN ALIGNMENT NG OK PERPENDICULARITY NG	BANDO GUN	Important reminders/Note/s: 1. Make sure no gap between stopper and terminals. 1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape BANDO GUN ILLUSTRATION GOOD REALT NOSEPIECE EXTENDED NOSEPIECE

				WORK INSTRUC	CTION		Effectivity Date:	April 24, 2023
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		Model Code/Part Number:	011B /	7M0365-7021	Customer:	TRJ	Document No.:	WI-ENG-PDE-418C
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.: 6 of 9
	1							
PARTS:	1. Assy	parts		JIG	n/a			
NO.	F	PROCESS NAME		WORK PROC	EDURE/ ILLUSTR	TOOLS/PPE	QUALITY POINTERS	
4	P3	Visual/By two's inspection	Assembled parts	Master lock, te	rts)		3. Check the presence of clamp tube and taping condition. 4. Check the connector lock, terminal, insertion and taping condition.	1. No skip checking during inspection

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			WORK INSTRU	JCTI	ON			Effectivity Date:		April 24	1, 2023
Process Name/Title:			TAPING A	SSE	EMBLY PRO	CESS		Validity Date:		n/	a
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PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILL USTRATION	TOOLS/	PPF	QUALITY POINTERS

5. Check the Y-Taping condition, presence of all clamp attachment, taping condition and band clamp cut condition.



6. Conduct bending of COT and tube then check the taping condition.



7. Check the **terminal appearance**. Must be **no deformed terminal**.

MASTER SAMPLE



1. No skip checking during inspection



Important reminders/Note/s:

1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.

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Visual/By two's inspection (Continuation)

NBC (Philippines)

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		Model Code/Part Number:	011B /	7M0365-702 ²	Customer		TRJ		Document No.:			WI-ENG-P	DE-418C	;
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								l						
PARTS:	n/a									JIG	n/a			
NO.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/	PPE	QI	JALITY P	OINTE	RS
5	P3	Measurement	5~8mm 116±5mm	104±5mm 5*8mm 50±5	Note 1 Plea whe		d/verified measur asurement.	ring tape 60±3mm	216±3mm		1. FOR OWAR	HATSUMONIMONO	NO AND	/s:

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PARTS: n/a			JIG	n/a
	QUALITY CHECK	POINTS		
P3	7M03	65-7021		
GOOD COOL		esker 2 COT 2		2
5	4		2) (2)	2
NO (2) No Missing	Clamp	(4)Conduct Be	nding on Sunp	rene tube
No Unlock/Halflock (6pcs.)		5 No De	formed	
Connector (on 2 connector) (3) Checking of	f Inside Spot	6 Checki	ng of Clamp Al	lignment