| PARTS: Model Codes Pear Number: 178D / TV0129-T020 Current: TRJ Document No.: WIENEPERS38A Member PERS38A MEMBE | | | | | WORK INS | | | | | Effect | tivity Date: | | January 06, 20 | 22 |
|--|------------|-------------|--------------------------------|---|--|---|--|-------------------------------|-------------------------------------|----------------|--|----------------------------|-----------------|--------------|
| Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No: 1 Page No: 1 of 9 PARTS: All parts: Connector 6188-0066 (GR): AVSS1 0.3 wires Y-OR L=584s2mm: Black Corrugated tube of L=2*14s3mm (no siti); Black Corrugated tube of L=2*14s3mm (no siti) Table Lay-out Black Corrugated tube of L=2*14s3mm (no siti) Connector 138-0068 (GR)/ Connector 138-0 | | Y. | Process Name/Title: | | TAPING | G ASSEMBLY P | ROCESS | | | Validi | ty Date: | | n/a | |
| A J. All parts: Connector 6189-0066 (GR); AVSST 0.3 wires V.OR L=384.22mm; Black Corrugated tube of L=274.62mm (no slit); Black Log (Inc.) NO. PROCESS NAME A WORK PROCEDURE/ ILLUSTRATION Table Lay-out Black Corrugated tube of L=274.62mm (no slit); Donnector 6189-0451 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm, Black Corrugated tube of L=574.62mm (no slit); Donnector 6189-0451 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm, Black Corrugated tube of L=574.62mm (no slit); Donnector 6189-055 (GR); Averaged tube of L=574.62mm (no slit); Donnector 6189-055 (GR); Averaged tube of T=274.62mm (no slit); Donnector 6189-055 (GR); Averaged tube of T=274.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62mm (no slit); Donnector 6189-055 (W); MRSW CP TVSSI 0.3 GR-BW L=262.62 | | | Model Code/Part Number: | 178D / | 7N0129-7020 | Customer: | TR | J | | Docur | ment No.: | | WI-ENG-PDE-3 | 39A |
| PARTS: Described to the property of the proper | | | Purpose: | PROTOTYP | E | PRE-LAUNCH | MASSI | PRO | | Revis | ion No.: | 1 | Page No.: | 1 of 9 |
| PARTS: Described to the property of the proper | | | - | | | | | | | | | | | |
| Table Lay-out Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, friger cots, etc.) Formulation Part Pa | PARTS: | 1 ø7 | L=116±3mm (no slit); Connector | GR); AVSSf 0.3 wires \ 6189-0451 (W); MRS\ | Y-OR L=384±2mm; Bla W CP TVSSf 0.3 GR-E | ack Corrugated tube ø7 L B/W L=822±3mm; Black | =214±3mm (no sli Corrugated tube ø | t); Black Corr 7 L=517±5mn | ugated tube n (no slit); | | JIG: | 2. Locking | jig | er |
| Be sure to wear required personal protective equipment during personal protective connector fis8-066 (fish) Connector fis8-065 (fish) Connector fis8-066 (| NO. | | PROCESS NAME | | / ₁ \ WORK P | ROCEDURE/ ILLU | STRATION | | | | TOOLS/PPE | | QUALITY POIN | TERS |
| 01/06/22 1 Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out; checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.) M. Catapang J. Loterte C. Villanueva A. Arañes | 1 | F | 71Table Lay-out | Insertion jig A | 0066 (GR)/ rtray | Black Corrugated tube 7 L=214±3mm (no slit) Black C Ø7 L=11 AVSSf 0.3 wires Y-OR L=384±2mm Terminal Cover ji | orrugated tube 5±3mm (no slit) MRSW CP TVSSf 0.3 iR-B/W L=822±3mm | Conne | k Corrugated tube 517±5mm (no | 1. 2. Polither | sure to wear requirersonal protective equipment during eration (gloves, fing cots, etc.) Housekeeping Maintain and alway practice 5's. Personal things on torkplace is prohibiteep it in your locker any trouble, inforie Assembly Assistar Supervisor or Line eader for immediate corrective action. | ys ! 1. No miss 2. No exce | ing parts/tools | Folerance |
| checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.) M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva D. Loterte D. | | | | | 1 CVISION I NSION | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
| 09/20/21 0 Initial issue M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva / A. Arañes | 01/06/22 1 | | | | | | | I later to | Villagua : | \ =0 == - | Allen I a a | | 17 ill | |
| | 09/20/21 | _ | | (IVEIEL IO WI-PRO-CINC-C | orrior write and only Len | igur roierance.) | | | | | | . I I oterte | C. Villanuava | A APPROS |
| | | | ai issuc | Details of C | hange | | | | | | | | | Z A. Aralles |

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| | | | WORK I | NSTRUC | CTION | | Effectivity Date: | | Janu | ary 06, 2022 |
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| | | Process Name/Title: | TAPI | NG AS | SEMBLY PR | OPCESS | Validity Date: | | | n/a |
| | | Model Code/Part Number: | 178D / 7N0129 | -7020 | Customer: | TRJ | Document No.: | | WI-EN | IG-PDE-339A |
| | | Purpose: | ☐ PROTOTYPE | [| PRE-LAUNCH | MASSPRO | Revision No.: | | 1 Page N | lo.: 2 of 9 |
| | | | | | | | | | | <u> </u> |
| PARTS: | 1. Conr | nector 6188-0066 (GR) | ۸ | | | | | JIG | 1. Insertion jig v | vith switch cover |
| NO. | F | PROCESS NAME | √ı\ WOR | K PROC | EDURE/ ILLUS | STRATION | TOOLS/P | PE | QUALIT | Y POINTERS |
| 2 | P1 | Connector setting to insertion jig 6188-0066 (GR) | Visual reference 1. Press the lock using left thumb. | Lock 2. Get t insertio | INSERTION J ORIENTATIO Press the connector 6188-0 n jig. Release the loc ollow the connector Hole 3. Pus | Release Release | n/a | | I-mark is align I-mark is not align | |

| | _ | | | WORK INSTRU | ICTION | | Effectivity Date: | | | January 0 | 06, 2022 |
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| | | Process Name/Title: | | | SEMBLY PROF | PCESS | Validity Date: | | | n/a | • |
| | | Model Code/Part Number: | 178D | / 7N0129-7020 | Customer: | TRJ | Document No.: | | | WI-ENG-P | DE-339A |
| | | Purpose: | ☐ PR | ОТОТҮРЕ | PRE-LAUNCH | MASSPRO | Revision No.: | | 1 | Page No.: | 3 of 9 |
| | | | | | | | | | 1 | | |
| PARTS: | 1. AVS | Sf 0.3 wires Y L=364±2mm; C |)R L=364±2mr | m A | | | | JIG | 1. Insert | ion jig with s | witch cover |
| NO. | F | PROCESS NAME | | √1 WORK PRO | CEDURE/ ILLUSTI | RATION | TOOLS/I | PPE | QI | JALITY P | OINTERS |
| 3 | P1 | Wire insertion to connector 6188-0066 (GR) | 1. Hold the Get the Yel slot 1 using | e insertion jig using left hand. Fillow wire then insert to terminal gright hand. Orange wire then insert to lot 2 using right hand. | 4. After insertiand then hold | Press the button using right thumb. The range wire will be opened. Press The press T | n/a | | 1. No loc 2. No wr 3. One b 4. No de 5. No wr Make su Conduct insertion Do not e | ose insertion ong insertion on ong insertion on ong wire factor ong wire factors wire wires are Pull-Push-I. | properly inserted. Pull-Push after rece. |

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| Process Name/Title: | | | TAPING AS | SEI | MBLY PROP | CESS | Validity Date: | | n/ | 'a |
| Model Code/Part Number: | 178D | 1 | 7N0129-7020 | (| Customer: | TRJ | Document No.: | | WI-ENG-F | PDE-339A |
| Purpose: | ☐ PI | ROTOTYP | E | | PRE-LAUNCH | MASSPRO | Revision No.: | 1 | Page No.: | 4 of 9 |

1. Black Corrugated tube ø7 L= 214±3mm (no slit) 3. Assy parts PARTS: JIG 1. Insertion jig 2. Black Corrugated tube ø7 L= 116±3mm (no slit) NO. **PROCESS NAME WORK PROCEDURE/ILLUSTRATION** TOOLS/PPE **QUALITY POINTERS** Wire insertion to COT (no slit) 1. No wrong use of parts 4 n/a ø7 L= 214±3mm (1ST) 2. No deformed terminal ø7 L= 116±3mm (2ND) 1. Hold the wires using left hand. Get the 2. Hold the wires using left hand. Get the Corrugated tube (no slit) ø7 L=214±3mm Corrugated tube (no slit) ø7 L=116±3mm using right hand then insert the Y-OR wires using right hand then insert the Y-OR wires using left hand. using left hand. **INSERTION JIG** I-mark P1 Visual reference Lock 1. Use the provided jig per model Connector setting to 2. No wrong orientation of connector 5 insertion jig n/a **Button** 3. No wrong use of connector 6189-0451 (W) 4. No damaged connector **INSERTION JIG ORIENTATION** Guide CONNECTOR ORIENTATION

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| | | | WORK | (INSTRUCTION | ION | | Effectivity Date: | | Ι , | January 06 | 5, 2022 |
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| | | Process Name/Title: | TA | PING ASSE | MBLY PROPCES | 3 | Validity Date: | | | n/a | |
| | | Model Code/Part Number: | 178D / 7N01 | 29-7020 | Customer: | TRJ | Document No.: | | ٧ | VI-ENG-PD | E-339A |
| | | Purpose: | PROTOTYPE | | PRE-LAUNCH | MASSPRO | Revision No.: | | 1 Pa | age No.: | 5 of 9 |
| | | | | | | | | | | | |
| PARTS: | 1. Con | nector 6189-0451 (W) | ٨ | | | | | JIG | 1. Insertior | n jig | |
| NO. | ı | PROCESS NAME | / ₁ \ WC | RK PROCED | URE/ ILLUSTRATIO | N | TOOLS/F | PPE | QUA | ALITY PO | DINTERS |
| 5 | P1 | Connector setting to insertion jig 6189-0451 (W) (Continuation) | 1. Press the lock using left thumb. | insertion jig. Note: Follow 3. Push the lower | Press onnector 6189-0451 (W) using the connector orientation. Hole or wire guide upward using for Yellow wire will be | | n/a | | I-mark is align I-mark is not align | GOOR STATE OF THE PROPERTY OF | thole is open tholes are open g per model on of connector onnector |

| | | | WORK INSTRUC | TION | Effectivity Date: | January 06, 2022 |
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| | | Process Name/Title: | TAPING ASS | SEMBLY PROPCESS | Validity Date: | n/a |
| | | Model Code/Part Number: | 178D / 7N0129-7020 | Customer: TRJ | Document No.: | WI-ENG-PDE-339A |
| | | Purpose: | ☐ PROTOTYPE [| PRE-LAUNCH MASSPRO | Revision No.: | 1 Page No.: 6 of 9 |
| | 1 | | | | | |
| PARTS: | 1. Assy | parts | ٨ | | JIG | 1. Insertion jig |
| NO. | F | PROCESS NAME | V1 WORK PROC | EDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 6 | P1 | Wire insertion to connector 6189-0451 (W) | 1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand. 3. Get the Orange wire then insert to terminal slot 2 using right hand. | 2. Press the button using right thumb. The slot for Orange wire will be opened. 4. After insertion, push the lock 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 Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure. |

| Process Name/Title: TAPING ASSEMBLY PROPCESS Validity Date: |
|---|
| PARTS: 1. Assy parts 2. MRSW CP TVSSf 0.3 GR-B/W L=822±3mm 3. Black Corrugated tube \$7 L=517±5mm (no slit) NO. PROCESS NAME Connector lock 1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked. 1. Get the terminal cover jig using right thand then insert to both terminals (GR-B/W wires) using right thand. 1. Get the terminal cover jig using right thand then insert to both terminals (GR-B/W wires) using right thand. |
| PARTS: 1. Assy parts 2. MRSW CP TVSSf 0.3 GR-B/W L=822±3mm 3. Black Corrugated tube \$\phi\$7 L=517±5mm (no slit) 1. Locking jig NO. PROCESS NAME Connector lock TOOLS/PPE QUALIT NOTE: MANUAL LOCKING JIG 1. Use the provice model 2. No unlock/hal and then press 2x. Touch the connector lock if properly locked. R 1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand. |
| NO. PROCESS NAME 1. Locking jig NO. PROCESS NAME 1. WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALIT NOTE: MANUAL LOC DAMAGED LO After pressing Properly locked. 1. Get the terminal cover jig using right thand then insert to both terminals (GR-B/W wires) using right hand. Note: Refer to Wire and Strip |
| NO. PROCESS NAME 1. Locking jig NO. PROCESS NAME 1. WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALIT NOTE: MANUAL LOC DAMAGED LO After pressing Properly locked. 1. Get the terminal cover jig using right thand then insert to both terminals (GR-B/W wires) using right hand. Note: Refer to Wire and Strip |
| Connector lock 1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked. 1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand. NOTE: MANUAL LOC DAMAGED LO 1. Use the provice model 2. No unlock/hal 3. No damaged I |
| Connector lock 1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked. 1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand. Note: Refer to Wire and Strip |
| P1 1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand. |
| Wire insertion to Black Corrugated tube (no slit) \$\phi 7 \text{L}=517\pm\$5mm \text{J. No wrong usa} 2. Get the corrugated tube \$\phi 7 \text{L}=517\pm\$5mm using right hand then insert the \$\mathbb{GR-B/W wires}\$ using left hand. 1. No wrong usa 2. No damaged in the cover jig using right hand. |

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| | | Process Name/Title: | | | TAPING AS | SEMBLY | PROPCES | 6 | Validity Date: | | | n/a | 1 |
| | | Model Code/Part Number: | 178D | / | 7N0129-7020 | Customer: | | TRJ | Document No.: | | | WI-ENG-P | DE-339A |
| | | Purpose: | ☐ PRO | OTOTYP | PE | PRE-LAUNC | Н | MASSPRO | Revision No.: | | 1 | Page No.: | 8 of 9 |
| | | | | | | | | | | l | | | |
| PARTS: | 1. Assy 2. Black | | | | ٨ | | | | | JIG | n/a | | |
| NO. | F | PROCESS NAME | | | √ı\work proc | EDURE/ ILI | USTRATIO | N | TOOLS/ | PPE | Q | UALITY P | OINTERS |
| 9 | P1 | Taping 1 Black corrugated tube to wire near PCB | 25 | 5±3mm | 2 3 4 5 6 46±3mm | 7 8 9 R | 2. Confirm me from end of ta continue the t hands. 3. Measure fr of hotmelted | | n/a | | 2. No pe 3. No loo 4. No m 5. No wi | p-out tape eel-off tape ose tape ossing tape rong dimensi rong use of ta | |

| | | | | | WORK INSTRU | CTION | | | Effectivity Date: | | | January 0 | 6, 2022 |
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| | | Process Name/Title: | | | TAPING AS | SEMBLY P | ROPCESS | ; | Validity Date: | | | n/a | ı |
| | | Model Code/Part Number: | 178D | 1 | 7N0129-7020 | Customer: | - | TRJ | Document No.: | | | WI-ENG-P | DE-339A |
| | | Purpose: | ☐ PR | ОТОТҮР | PE | PRE-LAUNCH | | MASSPRO | Revision No.: | | 1 | Page No.: | 9 of 9 |
| | 1 | | | | | | | | | | 1 | | |
| PARTS: | 1. Assy 2. Black | | | | Λ | | | | | JIG | n/a | | |
| NO. | ı | PROCESS NAME | | | √ ¹ WORK PROC | EDURE/ ILL | USTRATION | ı | TOOLS/ | PPE | Q | UALITY P | OINTERS |
| 10 | P1 | Taping 1 Black corrugated tube to wire near PCB (Continuation) | 7 8 | L | RN 1 2 3 | 46±3mm 9 6 0 1 23±3mm | from end of tag continue the ta hands. | asurement of 23±3mm be up to edge of PCB then uping process using both | | | 2. No pe 3. No lo 4. No m 5. No w | p-out tape eel-off tape ose tape issing tape rong dimensi rong use of ta | |