Process Name/Title:	1						WORK INST		Effectivity Date:		October 07, 2022		022				
PARTS: New years: Connector 7 186-8847 (W); Black COT (no sit) of L-76-3mm; Black COT (no sit) of L-78-3mm; MSS (0.3 % wire L-2002-2mm; MSS				Process Name/Title:			TAPINO	G ASSEMBLY PROC	ESS			Valid	ity Date:		n/a		
AVSS10.3 V wire L=465.22mm, AVSS10.3 V wire L=465.22mm, AVSS10.3 S wire L=465.22mm, AV				Model Code/Part Number:	TP1	1	7L0092-7021	Customer:	TRQSS	3		Docu	ment No.:		WI-ENG-PDE-0)63A	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTATION Table Lay-out Black COT (no sit)				Purpose:	□ F	PROTOTYP	PE	PRE-LAUNCH	MASS	PRO		Revis	sion No.:	7	Page No.:	1 of 9	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTATION Table Lay-out Black COT (no sit)																	
Table Lay-out Safety Instruction Be sure to wear prescribed personal protective equipment during operation (glove). Ingerion jig 6 Avssr 0.3 vwire L-28912mm Avssr 0.3 vwire L-28912mm Avssr 0.3 vwire L-28912mm Avssr 0.3 wire L-24912mm Avssr 0.3 wire L-28912mm Avssr 0.3 wi	PARTS:											m;	JIG:				
Black COT (no siti) Black	N	.0	Р	ROCESS NAME			WORK P	ROCEDURE/ ILLUSTR/	ATION				TOOLS/PPE		QUALITY POINTERS		
10/07/22 7 Improve quality pointers: References in process no.1,3,5,6,7,8,9 and 10 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.6 and 9 as countermeasure due to encountered terminal backing out. 04/12/22 6 Additional table layout. Transfer process no. 7 - 10 from P2 to P1 as improvement in overall process. 02/15/21 5 Change part number from 7L0092-7020A to 7L0092-7021 due to change in tape color from Black tape to Gray tape in process COT to wire near connector. Change COT length from L=79±3mm to L=66±3mm; L=69±3mm to L=66±3mm; a7 L=200±3mm to L=195±3mm due to encounter maximum dimension from T-Taping to terminal. Conduct review of documents. M. Catapang C. Villanueva A. Arañes M. Catapang D. Loterte C. Villanueva A. Arañes D. Loter			P1	Table Lay-out	ø5 L	Insertion	Black COT (no slit Ø7 L=78±3mm AVSSf 0.3 Y wire L=289±2mm Assy p	Black COT (no slit) Ø7 L=195±3mm A A Black tape/	Connector 7 Connector 7 Connector 7 Connector 7 AVSSf 0.3 V w L=455±2mm L=445±2mm L=260±	7186-8847 (Vector Tray		2. 1 	Be sure to wear prescribed personal rotective equipmering operation (glow finger cots, etc.) Housekeeping Maintain and alwar practice 5's. Personal things on proper in your locke and the prescribe from the prescribe and the pre	the int	to WI-PRO-CNC-017 gth Tolerance to WI-ENG-PDE-062 ASSEMBLY PROCES: sing parts/tools ess parts/tools	7L0092-7021 - S	
from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.6 and 9 as countermeasure due to encountered terminal backing out. M. Catapang J. Loterte C. Villanueva A. Arañes O2/15/21 5 Change part number from 7L0092-7020A to 7L0092-7021 due to change in tape color from Black tape to Gray tape in process COT to wire near connector. Change COT length from L=79±3mm to L=66±3mm; c7 L=200±3mm to L=195±3mm due to encounter maximum dimension from T-Taping to terminal. Conduct review of documents. M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang J. Loterte C. Villanueva A. Arañes M. Catapang A. Arañes		1	ı				Revision History		1	ı			Prepared by	Reviewed by	Approved by	Noted by	
02/15/21 5 Change part number from 7L0092-7020A to 7L0092-7021 due to change in tape color from Black tape to Gray tape in process COT to wire near connector. Change COT length from L=79±3mm to L=66±3mm; ø7 L=200±3mm to L=195±3mm due to encounter maximum dimension from T-Taping to terminal. Conduct review of documents. M. Catapang C. Villanueva A. Shimamura A. Arañes M. Catapang J. Liverte C. Villanueva A. Arañes	10/07/22	7	from end	of tape up to terminal pointed tip	35+3mm/-3m	nm to 35+3	8mm/-1mm as countermea	sure due to encountered minimum		J. Loterte	C.Villanueva	A. Arañes					
COT to wire near connector. Change COT length from L=79±3mm to L=66±3mm; a7 L=200±3mm to L=195±3mm due to encounter maximum dimension from T-Taping to terminal. Conduct review of documents. M. Catapang C. Villanueva A. Arañes M. Catapang J. Leferte C. Villanueva A. Arañes	04/12/22	6	Additiona	l table layout. Transfer process n	o. 7 - 10 from	P2 to P1 a	as improvement in overall	process.	M. Catapang	J. Loterte	C.Villanueva	A. Arañes					
Details of Change Revised Revised Approved Noted Est. Date: January 03, 2020		-	COT to w	rire near connector. Change COT	length from L n dimension fr	L=79±3mm rom T-Tap	n to L=76±3mm; L=69±3mr ing to terminal. Conduct re	m to L=66±3mm; ø7 L=200±3mm					···· catapange	J. Loverte	C. Villanueva	A. AEBAS	
	⊏II. Date	Rev. No]			Details of C	Change		Revised	Keviewed	Approved	inotea	Est. Date:	January 03, 2020			

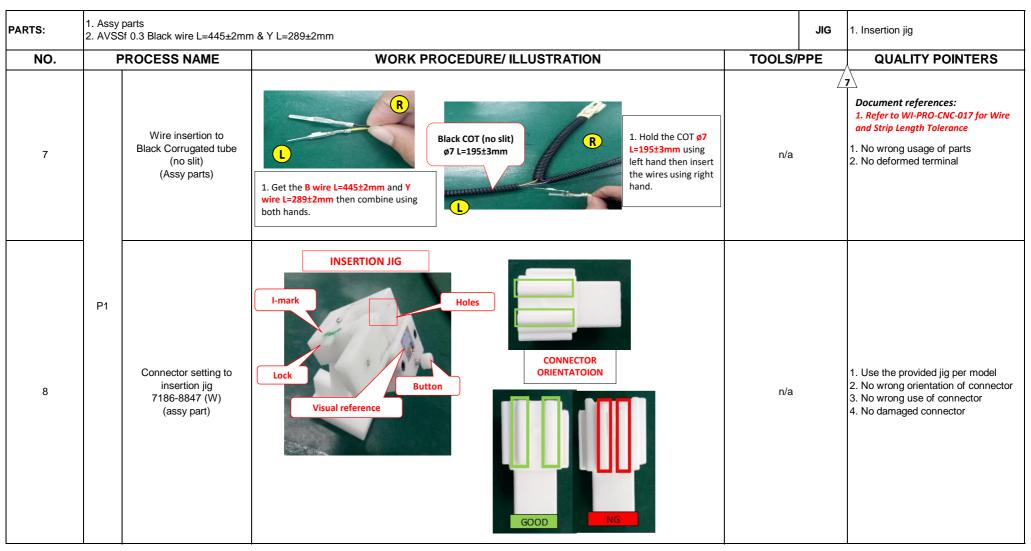
			WORK IN	STRUCTI	ION		Effectivity Date:		October 0	7, 2022
		Process Name/Title:	TAPI	IG ASS	EMBLY PROCE	SS	Validity Date:		n/a	1
		Model Code/Part Number:	TP1 / 7L0092-7	7021	Customer:	TRQSS	Document No.:		WI-ENG-PI	DE-063A
		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	7	Page No.:	2 of 9
		· ·								
PARTS:	1. Assy	parts Corrugated tube (no slit) ø5	1 76 2mm				JIG	1 To	rminal cover jig	
FARTS.	3. Back		L=70±311111				310	1. 16	Tillilai cover jig	
NO.	F	PROCESS NAME	WORK	PROCE	DURE/ ILLUSTRA	TION	TOOLS/PPE		QUALITY P	OINTERS
2		Wire insertion to Black Corrugated tube (no slit) ø5 L=76±3mm	1. Get the assy part and combine the V wire L=455mm using right hand and get the terminal cover jig using right hand		R	2. Get the corrugated tube (no slit) Ø5 L=76±3mm using right hand and insert the wires using left hand. 3. Remove the terminal cover jig after insertion using right hand.	TERMINAL COVER JIG	1. No	o wrong usage o o deformed term	
3	P1	Taping 1 COT to wire near terminal	Start of taping R 1. Hold the corrugated tube using left hand and get the Black tape then start taping using right hand.		ure from end of COT up to then continue taping pro		MEASURING TAP	1. No 2. No 3. No 4. No 5. No 6. No Imp 1. P med med Doc 1. R	Wire alignment Of lip-out tape Opeel-off tape Opeel-off tape Owrong use of to Owrong dimension Output	ape on ers/Note/s: ted/verified en getting the ces: PDE-588 for Tape

			WORK INSTRUC	TION		Effectivity Date:		October 07, 2022			
		Process Name/Title:	TAPING AS	SEMBLY PROC	ESS	Validity Date:			n	/a	
		Model Code/Part Number:	TP1 / 7L0092-7021	Customer:	TRQSS	Document No.:			WI-ENG-F	PDE-063A	
		Purpose:	PROTOTYPE [PRE-LAUNCH	MASSPRO	Revision No.:		7	Page No.:	3 of 9	
		<u> </u>						<u> </u>		<u> </u>	
PARTS:	1. Assy 2. Blac		L=78±3mm & ø7 L=195±3mm				JIG	n/a			
NO.		PROCESS NAME	WORK PROC	EDURE/ ILLUSTR	TOOLS/I	PPE	QI	JALITY I	POINTERS		
4	P1	Wire insertion to Black Corrugated tube (no slit) Ø7 L=78±3mm Ø7 L=195±3mm		using right hand the left hand. R 2. Get the corrugations of the corrugation of the cor	ated tube (no slit) ø7 L=78±3mm hen insert the V-OR wires using ated tube (no slit) ø7 L=195±3mm hen insert the V-OR wires using	n/a			rong usage Iformed terr		

	_			WORK INSTRUCTION	ON		Effectivity Date:		October	
		Process Name/Title:			EMBLY PROCE	SS	Validity Date:		n/	
		Model Code/Part Number:	TP1 / 7	7L0092-7021	Customer:	TRQSS	Document No.:		WI-ENG-P	DE-063A
		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		7 Page No.:	4 of 9
									<u>-</u>	
PARTS:	1. Conn	ector 7186-8847 (W)						JIG	1. Insertion jig	
NO.	F	PROCESS NAME		WORK PROCED	OURE/ ILLUSTRA	ΓΙΟΝ	TOOLS/F	PE	QUALITY F	OINTERS
5	P1	Connector setting to insertion jig 7186-8847 (W)	Insertice I-mark Visual reference 1. Press the lock of insusing left thumb. BEFORE PRESSING	Holes Button 2. Insertion jig A Note:	and release the lock. Follow the connector ori 3. Push	GOOD NG Release 847 (W) into jig using right entation. the guide using left thumb. t for OR wire will be opened.	n/a		I-mark is not align	All holes are open All holes are open All holes are open The property of th

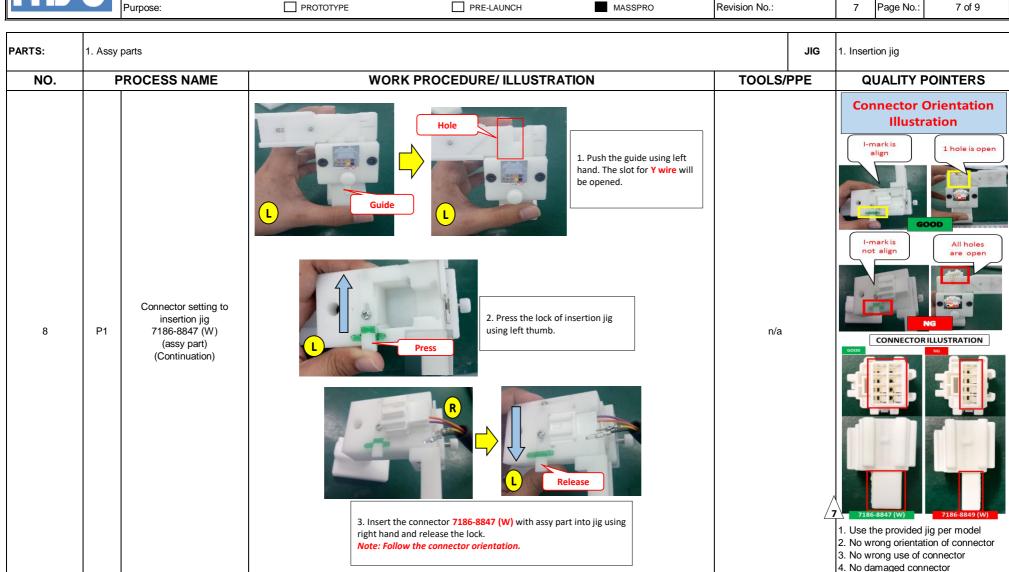
					WORK INSTR	UCT	ION			Effectivity Date:			October	07, 2022	
		Process Name/Title:			TAPING	ASS	EMBLY	PROCESS		Validity Date:			n	/a	
		Model Code/Part Number:	TP1	1	7L0092-702	1	Customer:	7	RQSS	Document No.:			WI-ENG-I	PDE-063A	
		Purpose:		PROTOTY	PE		PRE-LAUNC	Н	MASSPRO	Revision No.:		7	Page No.:	5 of 9	
		<u> </u>								<u> </u>					
PARTS:	1. Assy	parts									JIG	1. Insert	tion jig		
NO.	F	PROCESS NAME			WORK PR	OCE	DURE/ ILL	USTRATION		TOOLS/F	PPE	Q	UALITY I	POINTERS	
6	P1	Wire insertion to Connector 7186-8847 (W)	tern	. Hold the V w	orange ire then insert to ng right hand. Violet R ire then insert to using right hand.		5 44	2. After insertion of button using left h will be opened. Push 5. After from ji OR wii confirm	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. Tremoving the connector g, conduct Pushing (1x) of the using right hand to m that wire is fully the d. Repeat the process for the using right hand to m that wire is fully the d. Repeat the process for the using right hand to m that wire is fully the d. Repeat the process for the using right hand to m that wire is fully the d. Repeat the process for the using right hand to m that wire is fully the d. Repeat the process for the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m that wire is fully the using right hand to m the	n/a	<u></u>	2. No wi 3. One to 4. No de 5. No wi 1. Pleas termina 2. Make inserted Conduc after in. Do not 3. Inser will no Pull-P 4. Inser wire wi seconds 5. Cond removi 6. Push one by Documm 1. Refer Push pro 2. Refer	e sure wires d. t Pull-Pus sertion. exert extra ertion jig v t conduct ush metho tion jig will ll not insert s. luct Pushing ing the conn ing of wires one of ever ent referen to GL-PRO- ocedure.	on ition minal cing ers/Note/s: wire near s are properly h-Pull-Push force. will alarm if Pull-Push- d. alarm if Yello before 5 g of wires after ector from jig, will be done y inserted wire ces: aSY-029 for Pull CNC-017 for Wire	f

	WORK INSTRUCTION Process Name/Title: TAPING ASSEMBLY PROCESS										October 07, 2022			
Process Name/Title:		Validity Date:		n/a										
Model Code/Part Number:	TP1	1	7L0092-7021		Customer:	TRQSS		Document No.:			WI-ENG-P	DE-063A		
Purpose:		PROTOTYPI	=		PRE-LAUNCH	MASSPR	0	Revision No.:		7	Page No.:	6 of 9		



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			WORK INSTRU	ICTIC	ON			Effectivity Date:		October	07, 2022
Process Name/Title:			TAPING A	SSE	EMBLY PRO	OCESS		Validity Date:		n/	'a
Model Code/Part Number: TP1 / 7L0092-7021			Customer:	7	RQSS	Document No.:		WI-ENG-P	'DE-063A		
Purpose:		PROTOTYPE			PRE-LAUNCH		MASSPRO	Revision No.:	7	Page No.:	7 of 9



		Process Name/Title:	W	ORK INSTRUCT		DDOCESS	Effectivity Date:			October (
		Model Code/Part Number:	TP1 / 7L	L0092-7021	Customer:	TRQSS	Document No.:		n/a WI-ENG-PDE-063A			
		Purpose:	PROTOTYPE		PRE-LAUNC	Revision No.:		7	Page No.:	8 of 9		
PARTS:	1. Assy	•		WORK PROCE					1. Inser			
NO.		PROCESS NAME	TOOLS/	PPE	Q	UALITY P	POINTERS					
9	P1	Wire insertion to Connector 7186-8847 (W)	1. Hold the Y wire then insterminal slot 1 using right 2 1. Hold the B wire insert to	Yellow Assert to thand.	VIRE FACING	2. After insertion of Y wire press the button using left hand. The slot for B 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		2. No w 3. One 4. No de 5. No w Importe 1. Pleas termine 2. Make inserte Conduc after in Do not 3. Inse will no Pull-P 4. Inser wire wi second 5. Cond removii	e sure wires d. ct Pull-Pusi esertion. exert extra j ertion jig w et conduct Push method rtion jig will ill not insert ls. duct Pushing ing the conne	on tion ninal cing rs/Note/s: vire near are properly h-Pull-Push force. vill alarm if Pull-Push- d. alarm if Yellow	

Push

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 B wire.

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using right hand.

one by one of every inserted wires

1. Refer to GL-PRO-ASY-029 for Pull-

2. Refer to WI-PRO-CNC-017 for Wire

and Strip Length Tolerance

/7\Document references:

Push procedure.

		WORK INSTRUCTION	Effectivity Date:	October 07, 2022
	Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:	n/a
	Model Code/Part Number:	TP1 / 7L0092-7021 Customer: TRQSS	Document No.:	WI-ENG-PDE-063A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO	Revision No.:	7 Page No.: 9 of 9
PARTS:	1. AVSSf 0.3 Black wire L=260±2mn 2. Black tape	1 ^	JIG	n/a
NO.	PROCESS NAME	√7 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	Spot taping P1	2. Get the Black tape then conduct 2x windings of tape then cut using both hands. 1. Combine the B wire L=260±2mm to B wire L=445±2mm then measure the wire to terminal tip 100mm using both hands. 80 ± 3mm 3. After taping, check the measurement and taping condition.	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 1	Wire alignment tolerance 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance