PARTS: 1. Black tape 2. Assy part NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. Fix the viny' table 8. corrupated table indicated trape in the other side of corrugated table indicated indicated table indicated indicat						WORK INS							ectivity Date:				September 30,	2022
PARTS: 1. Black tape 2. Assy part NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE OUALITY POINTERS Safety Instruction Be sure to ware prescribed personal protective equipment. The protective equipment and always protective equipment. The protective equipment and the protective equipment and the protective equipment. The protective equipment and the protective equipment and the protective equipment and the protective equipment. The protective equipment and the pr			Process Name/Title:			TAPING	SASSEMBL	Y PROCES	SS			Vali	idity Date:				n/a	
PARTS: 1. Black tape 2. Assy part NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE Safety instruction Be sure to wear proscribed personal protective equipment during operation (gives, 5) In worning direction Luping direction Tape width Ta			Model code/Part number:	TP1	/ 7	L0091-7022	Customer:	T	RQSS			Doo	cument No.:				WI-ENG-PDE-0	61B
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Be sure to wear prescribed personal protective equipment during operation (glows, finger cots, etc.) 1. Fix the vinyfutube & corrugated tube find the tape 1/3 shifting until it reach the other side of corrugated tube find the tape shifting 9mm below 1. Fix the winyfutube & corrugated tube find the tape 1/3 shifting until it reach the other side of corrugated tube find the tape shifting 9mm below 1. Fix the winyfutube & corrugated tube find the tape to left side, width must be same with tape (19mm). 2. Start taping at the middle of combined Vinyfutube & Corrugated tube find the tape to left side, width must be same with tape (19mm). 3. Wind the tape 1/3 shifting 9mm below 1. Pease use calibrated/verified measuring tape when getting the measurement. 2. Jeed YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE to winding of tape. 3. Wind the tape 1/2 shifting going to other side of corrugated tube the condition of tape. Reviewed 1/2 shifting. Reviewed by Approved by Noted by No			Purpose:	PR	OTOTYPE	1	PRE-LAUNCH		MASSP	RO		Rev	vision No.:			5	Page No.:	1 of 7
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Be sure to wear prescribed personal protective equipment during operation (glows, finger cots, etc.) 1. Fix the vinyfutube & corrugated tube find the tape 1/3 shifting until it reach the other side of corrugated tube find the tape shifting 9mm below 1. Fix the winyfutube & corrugated tube find the tape 1/3 shifting until it reach the other side of corrugated tube find the tape shifting 9mm below 1. Fix the winyfutube & corrugated tube find the tape to left side, width must be same with tape (19mm). 2. Start taping at the middle of combined Vinyfutube & Corrugated tube find the tape to left side, width must be same with tape (19mm). 3. Wind the tape 1/3 shifting 9mm below 1. Pease use calibrated/verified measuring tape when getting the measurement. 2. Jeed YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE to winding of tape. 3. Wind the tape 1/2 shifting going to other side of corrugated tube the condition of tape. Reviewed 1/2 shifting. Reviewed by Approved by Noted by No		_											1					
Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. Fix the viny! tube & corrugated tube following the above illustration. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong dimension figure 5. No wrong dimension figure 5. No wrong dimension figure 5. No wrong dimension figure 6. No wrong dimension f	PARTS:		•											JIG	: n/	/a		
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Fix the vinyl tube & corrugated tube following the above illustration. 1. Please use calibrated/verified measuring the when getting the measurement. 2. Start taping at the middle of combined Vinyl tube & corrugated tube, then wind the tape to left side , width must be same with tape (25mm). 1. Please use calibrated/verified measuring the when getting the measurement. 2. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 3. Do not exert excessive force during pull windling of tape. 4. Wind the tape backward 1/2 shifting going to other side of corrugated tube for corrugated tube then cut the tape. After taping, check the condition of tape. 1. Please use calibrated/verified measuring the when getting the measurement. 2. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 3. Do not exert excessive force during pull windling of tape. 4. Wind the tape backward 1/2 shifting going to other side of corrugated tube for measurement. 5. Wind the tape 1/2 shifting going to other side of corrugated tube for measurement. 8. In protective equipment. 9. No line of the protective during protective for measurement. 9. No line of tape 1. No missing ta	NO.	P	ROCESS NAME			WORK PF	ROCEDURE/ I	ILLUSTRAT	ION				TOOL	S/PPE		G	QUALITY POIN	ITERS
, replaced in the control of the con	1			Corrug must b	rt taping at t gated tubes, be same wit	1. Fix the virifollowing the firection the middle of combined that the tape to the tape (19mm).	D GAP BETWEE In the second of	ted tube 3. Wind the tathe other side tape width) Tape wid	Tape shi	ting until it reted tube (mu	elow rugated	2 2 v	Safety Ins Be sure to prescribed protective of uring operate finger co Housek 1. Maintain practice. Personal the workplace is Keep it in your protection or immediate mactice. MEASURE 6 7 8 9 (1) 1 2	eeping and always level ble, infor ly Assistant Line Lead ce correct on.	ys 1. the taed. 2. vi si m 1. & & der ive	. No flip-ou . No peel-o . No loose . No missin . No wrong . Im Please usape when . Used YE isualizatio hould be . Do not ex	t tape ff tape tape g tape dimension portant reminder se calibrated/veri getting the measu LLOW TAPE for n of shifting line. BLACK TAPE xert excessive for of tape.	s/Note/s: fied measuring urement. easy s, but actual rce during pulling
		1.											Prepar	ed by	Revie	ewed by	Approved by	Noted by
109/30/22 5 Improve; Work procedure/Ilustration on process no. 1, 3 process no. 4 visual/by/two's inspection and process no. 5 measurement. Quality pointers; Reminders/notes on pg. 1 to 7.	09/30/22 5					no.4 visual/by/two's inspe	ection and process r		M. Ariola	J. Loterte	C. Villanueva	A. Arañes		1.04			<i>()</i>	
02/19/21 4 Change part number due to design change. Install color sensor to clamp assembly jig. D. Castillo C. Villanueva A. Shimamura A. Arañes				ge. Install cold	or sensor to	clamp assembly jig.		I	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes		_ '		Xm	South House	
10/24/20 3 Remove cycle time. D. Castillo R. Peñaloza A. Shimamura A. Arañes M. Ario)a J. Loberte C. Villanueva A. Arañes Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date: October 2, 2021		_	e cycle time.		etails of Ch	ange							+ +				C. Víllanúeva	/ A. Arade's
Lin. Data Nevised Nevised Nevised Nevised Nevised Noted List. Date. October 2, 2021	LII. Dale Kev. N	J I		D	ctans or One	ange			reviseu	reviewed	Approved	INOIGU	ı∟sı. Dale.		OCIODEI 2	۷, ۷۷۷ ۱		

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				WORK INST	RUC	TION			Effectivity Date:			September	30, 2022
		Process Name/Title:		TAPING	ASS	SEMBLY P	ROCESS		Validity Date:			n/a	1
		Model code/Part number:	TP1 /	7L0091-7022	2	Customer:	7	TRQSS	Document No.:			WI-ENG-P	DE-061B
		Purpose:	PROTO1	TYPE		PRE-LAUNCH		MASSPRO	Revision No.:		5	Page No.:	2 of 7
·													
PARTS:	1. Ureth 2. Assy	ane foam (GR) t=4; 75mm part	X 30mm							JIG	n/a		
NO.	PI	ROCESS NAME		WORK PRO	OCE	DURE/ ILLU	STRATION		TOOLS/	PPE	Q	UALITY P	OINTERS
2	P2	Urethane foam manual attachment to connector 7282-1020	to attach	Connector Step 3: Attached the				Step 4: Press the Urethane foam side by side after attachment.	n/a	,	2. No mi 3. No str Imp 1. Foam align 2. Follot based o 3. Do no 4. Toler. connect URE	n and connective the attach on the illustroist stretch the ance from the tor must be	ane foam hane sequence hation. hane Urethane foam hane foam to hane foam hane f

			V	VORK INSTRUCT	TION		Effectivity Date:		September 30, 2022
		Process Name/Title:		TAPING ASS	EMBLY PROCE	SS	Validity Date:		n/a
		Model code/Part number:	TP1 / 7L0	0091-7022	Customer:	TRQSS	Document No.:		WI-ENG-PDE-061B
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		5 Page No.: 3 of 7
PARTS:	1. Clam 2. Assy	o 82711-16830 (B) part						JIG	Clamp assembly jig
NO.	PF	ROCESS NAME	<u>/</u> 5	WORK PROCED	URE/ ILLUSTF	RATION	TOOLS/P	PE	QUALITY POINTERS
3	P2	Clamp Assembly	1. Put the assy. First, set the Second, set the connector to clamp location 1 using then press by Toggle clamp. 2. Check if all LED light for I	to Checker 2 for continuing both hands. Last, set the p. Continue if the sequen p. Continue if the sequen provided the sequen provided the sequence light is ON. If en the for further instruction provided the sequence light is ON. If en the sequence light is ON.	1 then pull the checke ity checking. Third, ge e B-B wires with term ice light of location (1 wirez, CLAMP ON, a incountered abnormaling then continue the p	er fixture for continuity checking. It the clamp 82711-16830(B) and set inal end together within the stopper was on. Ind COLOR SENSOR was ON. Check tty, STOP and immediately CALL the	Stopper SWITCH AL RICOR n/a	<u>/</u> <u>s</u>	1. No wrong use of clamp 2. No wrong set of clamp 3. No missing clamp 4. No loose band clamp 5. No super tight band cut Important reminders/Note/s: 1. Please check the clamp first before start of assembly to avoid wrong use of clamp. 2. Make sure no gap between terminal and stopper jig. 3. Terminal should touch the aluminum to check the continuity and sequence light will ON if the color sensor detect the GRAY TAPE. BAND CLAMP ILLUSTRATION GOOD NG 82711-16830 (B) 82711-34490 (B)

			1	WORK INSTRUC	CTION		Effectivity Date:	September 30, 2022
		Process Name/Title:		TAPING AS	SEMBLY PRO	DCESS	Validity Date:	n/a
		Model code/Part number:	TP1 / 7L	.0091-7022	Customer:	TRQSS	Document No.:	WI-ENG-PDE-061B
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 4 of 7
1	ı							
PARTS:	1. Clam 2. Assy	p 82711-16830 (B) part					JIG	1. Clamp assembly jig
NO.	PI	ROCESS NAME	<u>\</u>	WORK PROCE	DURE/ ILLU	STRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp Assembly (Continuation)	4. Get the bando gun an button after cutting. Go 5. CONDUCT POINT CHE 6. First, remove the controggle clamp. Last, remove the controgether with clamp.	d cut the band clamp (8 buzzer will be heard. CKING before removing the control of the control	ence light 82711-16830) usin g from jig.	g right hand. Press the sequence light BANDO GUN ALIGNMENT NG OK NG PERPENDICULARITY	BANDO GUN FLAT NOSEPIECE	1. No wrong use of clamp 2. No wrong set of clamp 3. No missing clamp 4. No loose band clamp 5. No super tight band cut Important reminders/Note/s: 1. Please check the clamp first before start of assembly to avoid wrong use of clamp. 2. Make sure no gap between terminal and stopper jig. 3. Setting of band cut cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4

					WORK INST	RUCTION			Effectivity Date:			Septembe	r 30, 2022
		Process Name/Title:			TAPING	ASSEMBLY	PROCESS		Validity Date:			n/	a
		Model code/Part number:	TP1	1	7L0091-7022	Customer:	TR	QSS	Document No.:			WI-ENG-F	DE-061B
		Purpose:		PROTOTYP	E	PRE-LAUNCH	· ·	MASSPRO	Revision No.:		5	Page No.:	5 of 7
<u> </u>		1							-		1		
PARTS:		mbled parts er sample			٨					JIG	n/a		
NO.	Р	ROCESS NAME			S WORK PR	OCEDURE/ ILL	USTRATION		TOOLS/	PPE	Q	UALITY F	POINTERS
4	P2	Visual Inspection/By Two's inspection			Master sample Ilignment of harness pple vs. Assembled both hands.		3. Check the clamp attach	presence of all	2. Check the termina insertion and taping condition.	.ll and	1.Using cut mearequire exceed (0~2mm	portant reming steel rule, asurement in dimension of the allowal on).	during inspection. inders/Note/s: check if the bands within the and should not ble range

		T		WORK INCTRUCT	101		F# # # B +		1	0 ()	22 222
		D 11 7711		WORK INSTRUCT		-00	Effectivity Date:			September	
		Process Name/Title:			EMBLY PROCE		Validity Date:			n/a	
		Model code/Part number:	TP1 /		Customer:	TRQSS	Document No.:			WI-ENG-PI	
		Purpose:	PROTOTYP		PRE-LAUNCH	MASSPRO	Revision No.:		5	Page No.:	6 of 7
							1				
PARTS:		mbled parts er sample						JIG	n/a		
NO.	P	ROCESS NAME		WORK PROCED	URE/ ILLUSTRA	TION	TOOLS/I	PPE	C	UALITY P	OINTERS
4	P2	Visual Inspection/By Two's inspection (Continuation)	4. Check th condition.	e terminal and insertion and	taping 5. Check the Y-TAPING condition.	6. Check th	ACTUAL PRODUCTION OF THE PRODU		1. No si	MASTER SA	AMPLE Juring inspection.

					WORK INS	TRUC	ΓΙΟΝ			Effectivity [ate:		Septer	nber 30,	2022
		Process Name/Title:			TAPING	G ASS	EMBLY P	ROCESS		Validity Dat	e:			n/a	
		Model code/Part number:	TP1	1	7L0091-7022		Customer:	7	rqss	Document	lo.:		WI-EN	G-PDE-	061B
		Purpose:		PROTOTYPE			PRE-LAUNCH	-	MASSPRO	Revision N	u:	5	Page N	0.:	7 of 7
												1			
PARTS:	n/a										JIG	n/a			
NO.	PI	ROCESS NAME			∆ WORK P	ROCE	OURE/ ILLU	STRATION		TOO	LS/PPE	G	≀UALIT	Y POII	NTERS
5	P2	Measurement			203±5mm	63±5n	connector	inyl tube to	355±3mr	MEASURING 6 7 8 9 (1) 1 2 3 4	TAPE	5 Im 1. For I 2.Pleas measu	Hatsumo se use ca	eminder no and	rs/Note/s: Owarimono. I/verified vetting the