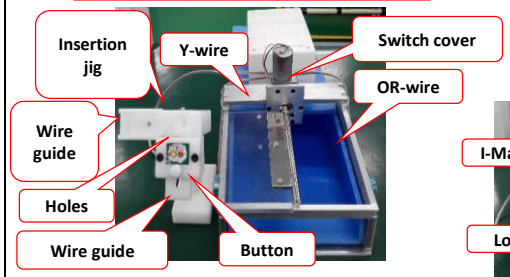
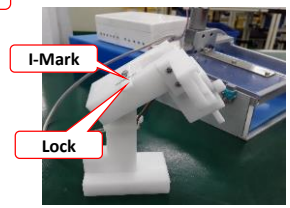
NBC	WORK INSTRUCTION			Effectivity Date:	October 6, 2021
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	500B / △4 7L0084-7021	Customer: TRQSS	Document No.:	WI-ENG-PDE-043A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4 Page No.: 1 of 11

PARTS:	1. Connector 6189-0451 (W)	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Connector setting to insertion jig 6189-0451 (W)			

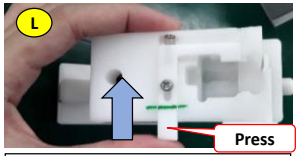
INSERTION JIG WITH SWITCH COVER



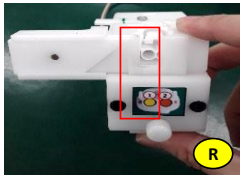


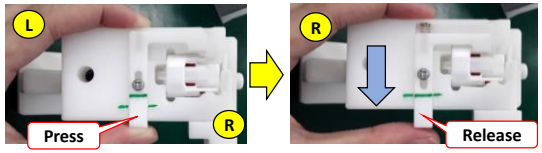
INSERTION JIG ORIENTATION

CONNECTOR



1. Press the lock of insertion jig using left thumb.





2. Insert the connector **6189-0451 (W)** into jig using right hand then release the lock using left thumb. ***Note: Follow the connector orientation.***

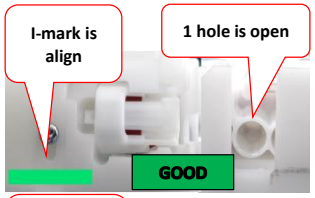
3. Push the guide using right thumb. The slot for **Yellow wire** will be opened.

Safety Instruction
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

CONNECTOR ORIENTATION ILLUSTRATION



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
10/06/21	4	Change part number from 7L0084-7020A to 7L0084-7021 due to design change. Additional guidelines for Pull-Push-Pull-Push method (Refer to GL-PRO-ASY-029 for Pull-Push procedure).	D.Castillo	J.Loterte	C. Villanueva	A. Arañes
02/20/21	3	Remove cycle time; Change 2x pulling to Pull-Push-Pull-Push; Change connector colors in accordance with color standardization for plastic parts (Please refer to GL-COM-003).	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
10/28/19	0	Initial issue	J. Loterte	A. Shimamura	A. Arañes	-

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	J. Loterte	C. Villanueva	A. Arañes

Est. Date: October 28, 2019

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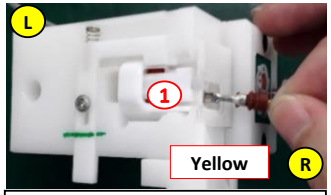
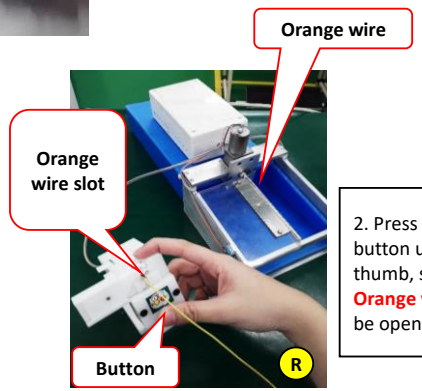
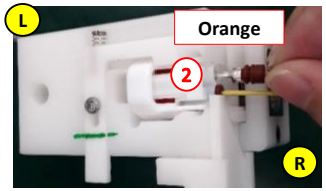
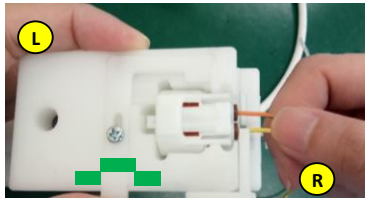
	WORK INSTRUCTION			Effectivity Date:	October 6, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 500B / △4 7L0084-7021	Customer:	TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 2 of 11

PARTS:	1. AVSSf wire Yellow L=329mm 2. AVSSf wire Orange L=329mm	JIG	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire Insertion to Connector 6189-0451 (W)	 WIRE FACING  1. Hold the insertion jig using left hand, get **Yellow wire** and insert to connector slot **1** using right hand.  2. Press the button using right thumb, slot for **Orange wire** will be opened.  3. Hold the insertion jig using left hand, get **Orange wire** and insert to connector slot **2** using right hand.  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. △4 *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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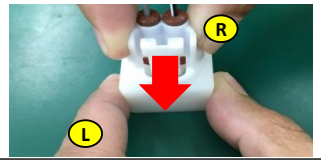
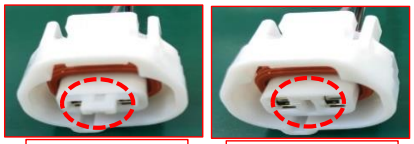
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 500B / △4 7L0084-7021	Customer:	TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 3 of 11

PARTS:	1. Assy parts 2. Black Vinyl tube Ø7 L=57±3mm 3. Black tape	JIG	1. Locking jig 2. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Connector lock	 1. Put the connector into locking jig using right hand then press **2x.** Touch the connector lock if properly locked.  Before pressing / After pressing	LOCKING JIG 	***NOTE:*** ***MANUAL LOCKING MAY CAUSE*** 1. Use the provided locking jig per model 2. No unlock/half-lock connector
4		Wire insertion to Black vinyl tube Ø7 L=57±3mm	 1. Get the cover jig then insert to **Y-OR wires** using right hand. 2. Get the vinyl tube **Ø7 L=57±3mm** using right hand then insert the **Y-OR wires** using left hand. 3. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No damaged rubber seal

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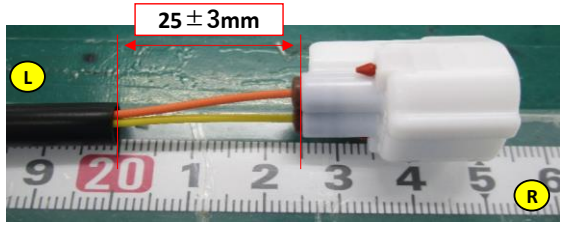
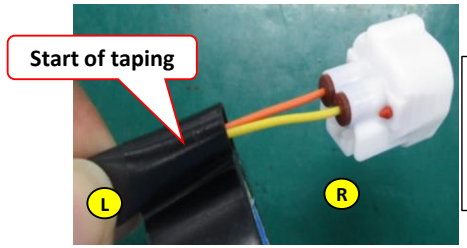
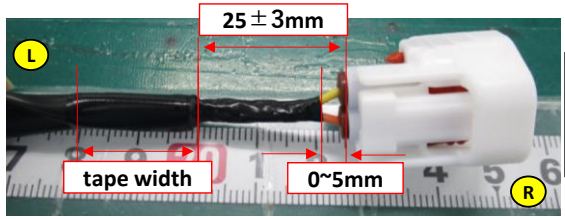
	Model code/Part number:	500B / ⚠4 7L0084-7021	Customer: TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.: 4 of 11

PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Taping 1 Black vinyl tube to wire near connector	 1. Measure from end of vinyl tube up to edge of connector **25±3mm** using both hands.  2. Get the **Black tape** using right hand then start taping process using both hands. ***Note: Please refer to WI-PRO-ASY-001 for taping procedure.***  3. After taping, check the measurement, wire alignment and taping condition.	**MEASURING TAPE** 	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* 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

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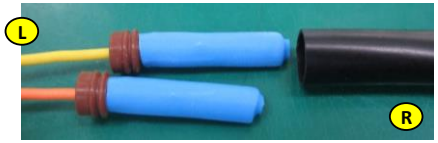
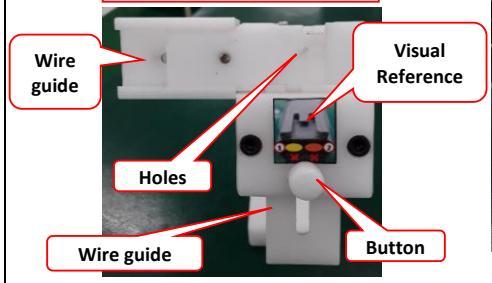
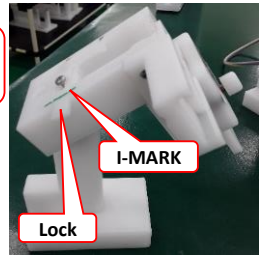
PARTS:	1. Assy parts 2. Black vinyl tube Ø7 L=189±3mm 3. Connector 6188-0066 (GR)	JIG	1. Terminal cover jig 2. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to Black vinyl tube Ø7 L=189±3mm	 1. Get the cover jig then insert to **Y-OR wires** using right hand.  2. Get the vinyl tube **Ø7 L=189±3mm** using right hand then insert the **Y-OR wires** using left hand. 3. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No damaged rubber seal
7		Connector setting to insertion jig 6188-0066 (GR)	INSERTION JIG FOR Y/OR  INSERTION JIG ORIENTATION  CONNECTOR ORIENTATION	n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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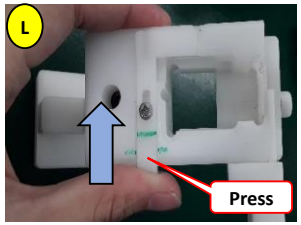
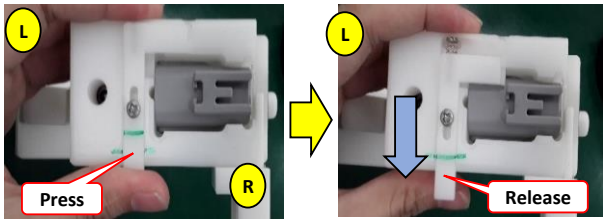
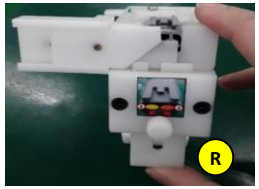
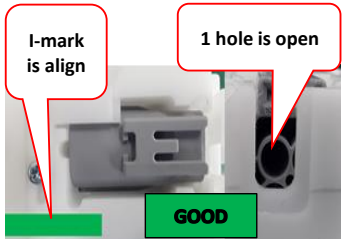
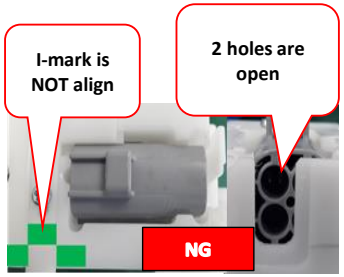
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 500B / △4 7L0084-7021	Customer:	TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 6 of 11

PARTS:	n/a	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Connector setting to insertion jig 6188-0066 (GR) (Continuation)	 1. Press the lock of insertion jig using left thumb.  2. Insert the connector **6188-0066 (GR)** into jig using right hand then release the lock. ***Note: Follow the connector orientation.***  3. Push the guide using right thumb. The slot for **Y wire** will be opened.	n/a	**Connector Orientation Illustration**   1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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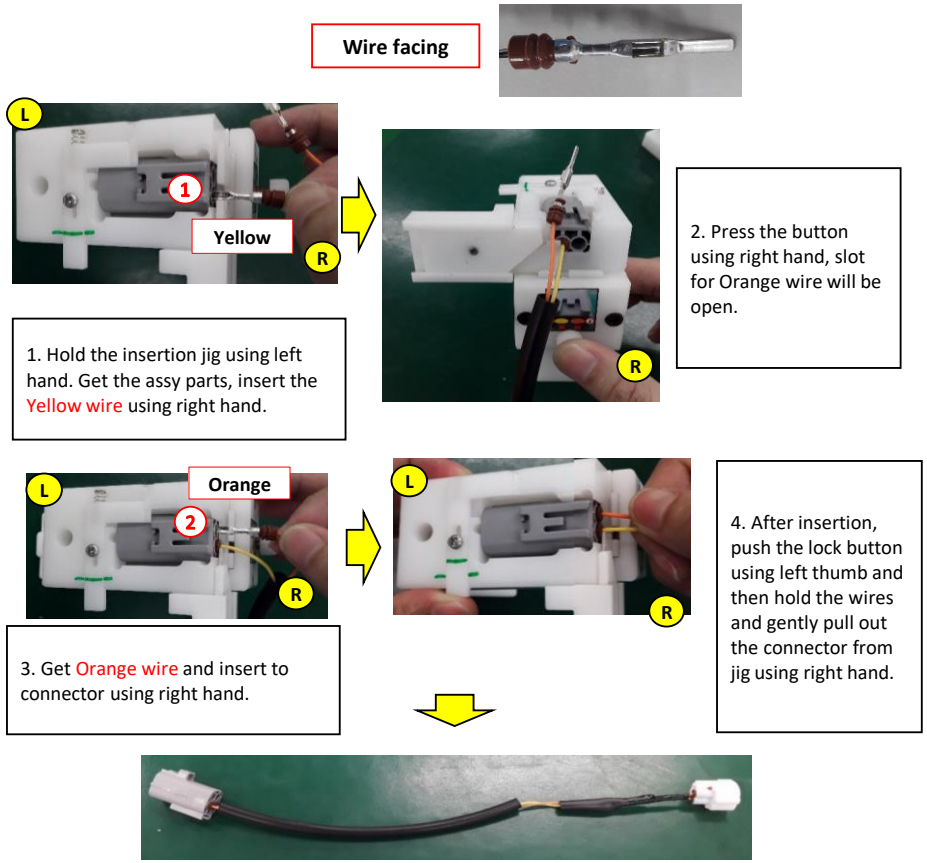
	Model code/Part number: 500B / △4 7L0084-7021	Customer:	TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 7 of 11

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Wire insertion to Connector 6188-0066 (GR)		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. △4 *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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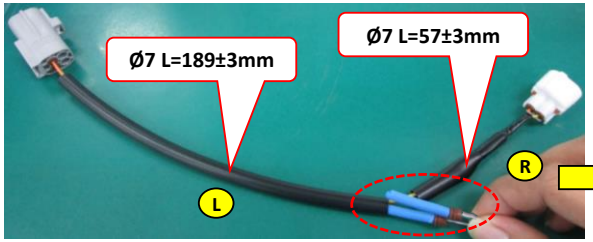
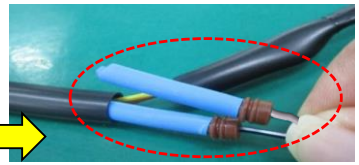
	Model code/Part number: 500B / △4 7L0084-7021	Customer:	TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 8 of 11

PARTS:	1. Black Corrugated tube Ø7 L=397±3mm (no slit) 2. MRSW CP A7475-7L0084-7050 (TVSSf wires GR/BW L=808mm; Sunprene tube Ø5 L=106±3mm) 3. Assy parts	**JIG**	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to Black corrugated tube (no slit) Ø7 L=397±3mm	 1. Get the cover jig then insert to **GR-B/W wires** using right hand. 2. Get the corrugated tube (no slit) **Ø7 L=397±3mm** using right hand then insert the **GR-B/W wires** using left hand.		
10		Wire insertion to assy parts	  1. Hold the vinyl tube(no slit) **Ø7 L=189±3mm** using left hand then insert **GR-B/W wires** using right hand. 2. After insertion, remove the cover jig using right hand.	**TERMINAL COVER JIG** 	1. No wrong usage of parts 2. No damaged rubber seal 3. No wrong insertion

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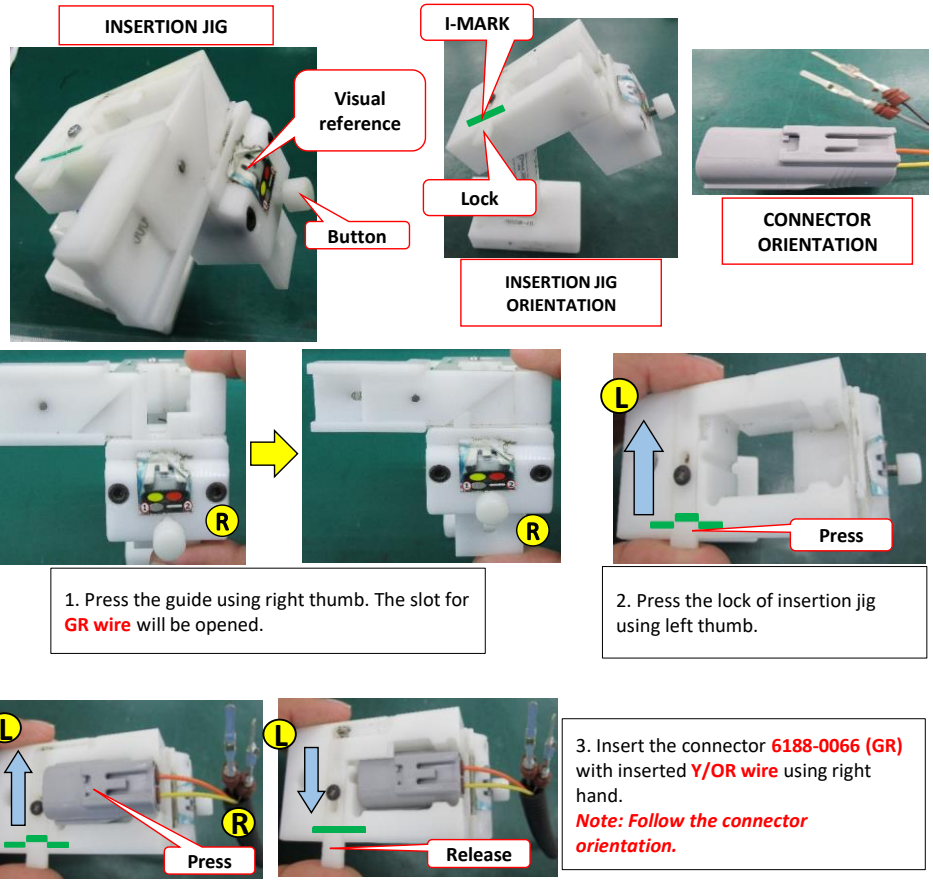
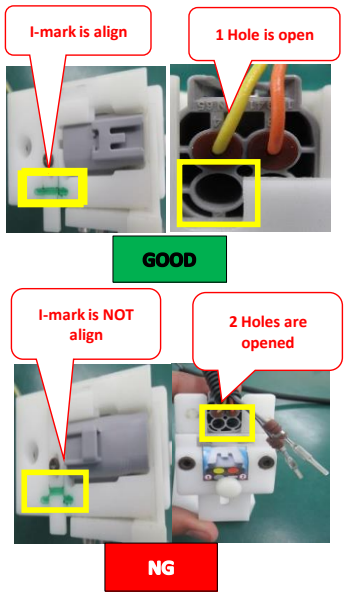
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 9 of 11

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	 1. Press the guide using right thumb. The slot for **GR wire** will be opened. 2. Press the lock of insertion jig using left thumb. 3. Insert the connector **6188-0066 (GR)** with inserted **Y/OR wire** using right hand. ***Note: Follow the connector orientation.***	n/a	**Connector Orientation Illustration**  △4 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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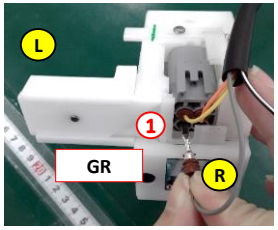
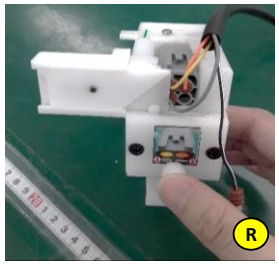
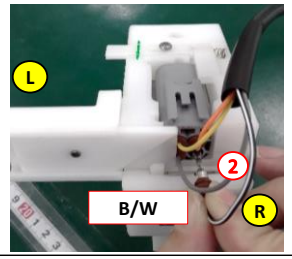
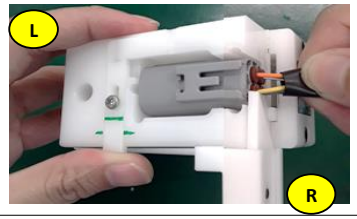
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.: 10 of 11

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Wire insertion to Connector 6188-0066 (GR)	 1 Hold the **GR wire** then insert to terminal slot **1** using right hand. WIRE FACING  2. Press the button using right thumb. The slot for **B/W wire** will be opened.  3. Hold the **B/W wire** then insert to terminal slot **2** using right hand.  4. After insertion, push the lock using left thumb 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. △4 *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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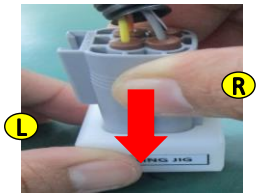
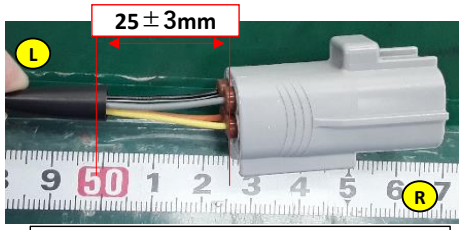
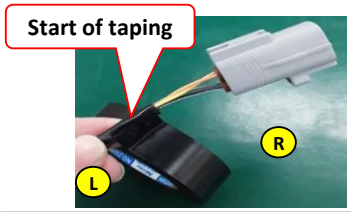
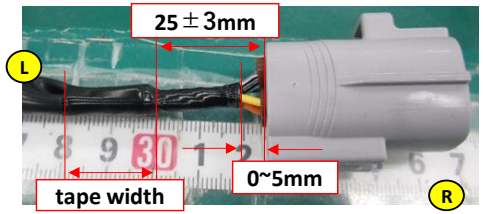
	WORK INSTRUCTION			Effectivity Date:	October 6, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number:	500B / △4 7L0084-7021	Customer: TRQSS	Document No.:	WI-ENG-PDE-043A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.: 11 of 11

PARTS:	1. Assy parts 2. Black tape	JIG	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1	Connector lock	 1. Put the connector into locking jig using both hands and then press **2x.** Check the connector if properly locked. Before pressing After pressing Coupler Cross Sectional View NG NG GOOD Unlock / Half Lock Condition / Full Lock Condition	LOCKING JIG 	***NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK*** 1. No half-locked and unlock 2. No lock deformation 3. Use provided jig tool to lock the connector
14		Taping 2 Black vinyl tube to wire near connector	 25±3mm 1. Measure from end of vinyl tube up to edge of connector **25±3mm** using both hands.  Start of taping 2. Get the **Black tape** using right hand then start taping process using both hands. ***Note: Please refer to WI-PRO-ASY-001 for taping procedure.***  25±3mm tape width 0~5mm 3. After taping, check the measurement and taping condition.	MEASURING TAPE 	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* 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

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