PARTS:  1. Connector setting to meeting in part of the connector orientation  Part Inc.  1. Connector setting to meeting in part or orientation  Part Inc.  1. Connector setting to meeting in mount in part or orientation  Part Inc.					NSTRUCTION		Effectivit	y Date:		Febru	ary 24, 2023	
PARTS: 1. Connector PRIVP-10V-S (W) [2]pcs]  NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION  TOOLS/PPE  OUALITY POINTERS  Safety Instruction Be sure to wear prescribed personal protective equipment during operation (given, finger) and finger operation (given, finger) and personal protective equipment during operation (given, finger) and finger) and finger operation (given, finger) and fin			Process Name/Title:	TAP	ING ASSEMBLY PROCESS	3	Validity [	Date:			n/a	
PARTS:  1. Connector PBVP-10V-S (W) [Spoel]  NO.  PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TOOLS/PPE  QUALITY POINTERS  Safety Instruction Be sure to wear prescribed; personal prosective equipment during operation (gloves, finger cots, etc.)  1. Use the provided jig per model procedure (gloves, finger cots, etc.) 2. Moving usage of parts Note: Follow the connector orientation.  PROCESS NAME  Connector selting to provide (gloves, finger cots, etc.)  1. Use the provided jig per model personal prosective equipment during operation (gloves, finger cots, etc.) 2. Noving usage of parts Note: Follow the connector orientation.  Note: Follow the connector orientation.  Alert Level  For any trouble, inform the Ascentibly Assistant is Supervised on the Loader for inmediate connector.  Alert Level  For any trouble, inform the Ascentibly Assistant is Supervised on the Loader for inmediate connector.  Revision Nature  Procedure  Villamova  And Androla  J. Loete  Villamova  Androla  Lucet  Villamova  Vi			Model Code/Part Number:	400B / 75N241-	<b>0040</b> Customer:	TRJ	Docume	nt No.:		WI-EN	IG-PDE-093	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS    Process			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision	No.:	6	Page No.:	1 of	f 14
1 P1 Connector setting to insertion jig PBVP-10V-S (W) Insertion jig PBVP-	PARTS:	1. Coni	nector PBVP-10V-S (W) [2pr	cs]					JIG:	1. Insertion jig		
Safety Instruction Be sure to wear prescribed personal protective equipment during operating (slower, finger cots, etc.)  1. Get the 2 per of PBVP-10V-5 (connector orientation)  1. Get the 2 per of PBVP-10V-5 connector using right hand transfer the personal follower, finger cots, etc.)  1. Use the provided jig per model personal (slower, finger cots, etc.)  1. Use the provided jig per model personal (slower, finger cots, etc.)  1. Use the provided jig per model personal (slower, finger cots, etc.)  2. Press the upper and lower guide using left hand then meet to insertion jig.  Alert level For any trouble, inform the Assembly Assistant is Supervisor or time Leader for immediate corrective action.  Revision History  2. Press the upper and lower guide using left hand in same timing, Holes that need to be insert are only one personal training and procedure. The personal training and procedure insertion jig and procedure. Changed term of Supervisor Or Unit Leader for immediate corrective action.  Revision History  2. Press the upper and lower guide using left hand in same timing, Holes that need to be insert are only one personal left than the insertion jig and procedure. Changed term of Supervisor of Unit Leader for immediate corrective action.  Revision History  2. Press the upper and lower guide using left hand in same timing, Holes that need to be insert are only one personal left than the procedure insertion jig and procedure. Changed term of Suppervisor of Williamson include quality checkpoths (Page 14).  2. Press the upper and lower guide using left hand transfer the personal training approach to the process illustration. Mingraph of the process illustration. Mingraph 1 and 2 due to the process improvement. Additional quality pointers in wire insertion.  2. Desirible J. Liberto Villanuary A. Arabics M. April D. Liberto Villanuary A. Arabics M. April D. Liberto Villanuary A. Arabics M. April D. Liberto Villanuary A. A. Arabics M. April D. Liberto Villanuary A. A. Arabics M. April D. Liberto Villanuary A. A. Ar	NO.	Р	ROCESS NAME	WORK	( PROCEDURE/ ILLUSTRATIO	N	7	OOLS/PP	E	QUAL	ITY POINT	ERS
6 Change VM tube (sunprene) from Brown VM Tube (Sunprene) TO Dark Brown VM tube (sunprene); Improve work  D. Castillo  J. Loterte  C. Villanueva  A. Arañes  M. Ariola  J. Loterte  C. Villanueva  A. Arañes	1	P1	insertion jig	Insertion Jig  2. Press the upper and be insert are only oper	Upper Button Lower guide  1. Get the 2 pcs of PBVP-10V-S connector 1 connector to left hand then insert to ins Note: Follow the connector orientation.  Press  Ø8  Press  O2.5  Ø8  Press  O8  I ower guide using left hand in same timing. Here.	ug7.5 Ø8  ug97.5 Ø8  using right hand transferention jig.	Be surium per eccoperation of the A Super	e to wear pres resonal protect juipment during (gloves, focts, etc.)  Ousekeepin aintain and also practice 5's. sonal things oplace is prohibe of it in your loc.  Alert level my trouble, infessembly Assis visor or Line Lemediate correaction.	g vays n the iited. ker.	No wrong us     No wrong or     No damaged	age of parts ientation of cor	
6 procedure/Illustration.  M. Ariola J. Loterte Villanueva A. Arañes  O2/16/23 5 Improved the insertion jig and procedure. Changed term of Sunprene tube to VM tube (Sunprene). Improved work procedure/illustration. Inlcude quality checkpoints (Page 14).  O9/22/22 4 Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Update By two's inspection.  M. Ariola J. Loterte Villanueva A. Arañes  D.Castillo J. Loterte C. Villanueva A. Arañes  M. Ariola J. Loterte C. Villanueva A. Arañes  M. Ariola J. Loterte C. Villanueva A. Arañes		1			•			Prep	ared by:	Reviewed by:	Approved by:	Noted by:
procedure/illustration. Inicude quality checkpoints (Page 14).  Uniform procedure/illustration. Inicud		procedu	re/Illustration.				Villanueva A.					
09/22/22 4 Improve process indistration. Merged P1 and P2 due to the process improvement. Additional quality pointers in whe insertion D.Castillo D.Castil	02/10/23 5					D.Casillo J. Loterte		Aranes	D1. O. A.			0
Eff. Date Rev. No     Details of Change     Revised     Reviewed     Approved     Noted     Established Date:     October 04, 2019		refer to		d Strip Length Tolerance. Update By two				M.	Ariola			A. Aranes
	Eff. Date Rev. No	)		Details of Change		Revised Reviewed	Approved	Noted Establ	ished Date	e: Octob	per 04, 2019	

				WORK INSTRI	UCTION		Effectivity Date:	February 24, 2023
		Process Name/Title:		TAPING A	SSEMBLY PR	ROCESS	Validity Date:	n/a
		Model Code/Part Number:	400B /	75N241-0040	Customer:	TRJ	Document No.:	WI-ENG-PDE-093
		Purpose:	PROTOT	YPE	PRE-LAUNCH	MASSPRO	Revision No.:	6 Page No.: 2 of 14
PARTS:	I = 208 + 2		·	·	n; R/W L=208±2m; (	GR L=130±1mm; LG L=208±2mm; OR L=	:208±2mm; R/L   <b>JIG</b>	1. Insertion jig
NO.	PI	ROCESS NAME		WORK PROC	CEDURE/ ILLUS	STRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the P wire us G-B/W-BR-R/W-GR-	IENCE FROM LEFT TO RIGHT  O S G Q 8 9 10  R  Ing left hand and transfer to LG-OR-R/L. Check the wire a certion sequence based on the	1 2 3 P G 130 130	Wire facing  4	STEERING NAVIGATION  CONTROLLER	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  Important reminders/Note/s: 1. Please hold the wire near terminal during insertion.  2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.  Do not exert extra force.  Document References: 1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
3	<u>/e</u>	Wire insertion to Dark Brown VM tube (Sunprene) Ø7.5 L=85+2/-3mm	L	R		1. Get the Dark Brown VM tube (Sunprene) Ø7.5 L=85+2/-3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.	N/A	No wrong usage of parts     No deformed terminal     No tangled wires

					WORK INSTRU	CTION			Effectivity Date:		February 24, 2023	
		Process Name/Title:			TAPING AS	SEMBL'	Y PROCESS		Validity Date:		n/a	
		Model Code/Part Number:	400B	1	75N241-0040	Custome	er: <b>TR</b>	<del>(</del> J	Document No.:		WI-ENG-PDE-093	
		Purpose:	□Р	ROTOTYPE		PRE-LAUN	ICH	MASSPRO	Revision No.:		6 Page No.: 3 of	14
									<u> </u>		<u> </u>	
PARTS:	1. AVSS	S 0.3 V L=130±1mm; B L=1	30±1mm; Y I	_=130±1n	nm; GR/B L=130±1mm;	R L=130±1m	ım			JIG	1. Insertion jig	
NO.	P	ROCESS NAME			<b>♠</b> WORK PROC	EDURE/ II	LUSTRATION		TOOLS/	PPE	QUALITY POINTER	S
4	P1	Wire insertion to Connector PBVP-10V-S (W)		CONTRACTOR OF THE PARTY OF THE	VINITURE ROM LEFT TO RIGHT  V  130	2 3 B X 130 X	Wire facing  4 5 6  Y GR/B  130  Note: Holes that need to open.  Lower guide	7 8 9 10 X X X R 130	STEERII NAVIGAT	TION	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  Important reminders/Note/s. 1. Please hold the wire near terminal during insertion. 2. Make sure wires are proper inserted. Conduct Pull-Push-Push after insertion. Do not exert extra force.  Document References: 1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 2. Refer to WI-PRO-CNC-017 for and Strip Length Tolerance 3. Refer to GI-PRO-ASY-028 for Push procedure.	ly <u>ıll-</u> Wire

				WORK INSTRU	CTION			Effectivity Date:		February 24, 2023
		Process Name/Title:		TAPING AS	SEMBLY PR	OCESS	6	Validity Date:		n/a
		Model Code/Part Number:	400B /	75N241-0040	Customer:		TRJ	Document No.:		WI-ENG-PDE-093
		Purpose:	PROTOTYPE	Ē	PRE-LAUNCH		MASSPRO	Revision No.:		6 Page No.: 4 of 14
	ı							<u> </u>	1	
PARTS:	1. Black	VM tube (Sunprene) Ø8 L	.=85+2/-3mm						JIG	1. Insertion jig
NO.	PI	ROCESS NAME		WORK PROC	EDURE/ ILLUS	<b>TRATIO</b>	N	TOOLS/	PPE	QUALITY POINTERS
5	P1	Wire insertion to Black VM tube (Sunprene) Ø8 L=85+2/-3mm		tube (Sunprene) Ø8 L=85+ d the wire using left hand t	Ø8 3. Remand Dahand the Check to Note: S	rk Brown VI ien press th he wire inso econd conn	2. Press the Upper button using left hand.  connector with inserted wires M tube (Sunprene) using right the upper guide using left hand. ertion condition. elector with inserted wire and inprene) will stay in the jig.	N/A		1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires  Terminal tip must be visible  Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
6		Wire insertion to assy parts	L	R	75A/41-0040 J1-A		1. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Dark Brown VM tube (Sunprene) using right hand.	N/A		No wrong use of parts     No deformed terminal     No tangled wires

			WOF	RK INSTRUCTION		Effectivity Date:	February 24, 2023
		Process Name/Title:	7	TAPING ASSEMBLY	PROCESS	Validity Date:	n/a
		Model Code/Part Number:	400B / 75N2	<b>241-0040</b> Customer	TRJ	Document No.:	WI-ENG-PDE-093
		Purpose:	PROTOTYPE	PRE-LAUN	CH MASSPRO	Revision No.:	6 Page No.: 5 of 14
	I						
PARTS:	1. Assy	parts				JIG	1. Insertion jig
NO.	PI	ROCESS NAME	W	ORK PROCEDURE/ IL	LUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire insertion to Connector PBVP-10V-S (W)	right hand. Repeat the process	1 2 3 V B B/W 130 130 208	1. Press the Lower button using right hand. Holes that need to be insert are only open.  R  L  R  R  R  R  R  R  R  R  R  R  R		1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.  Document References: 1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

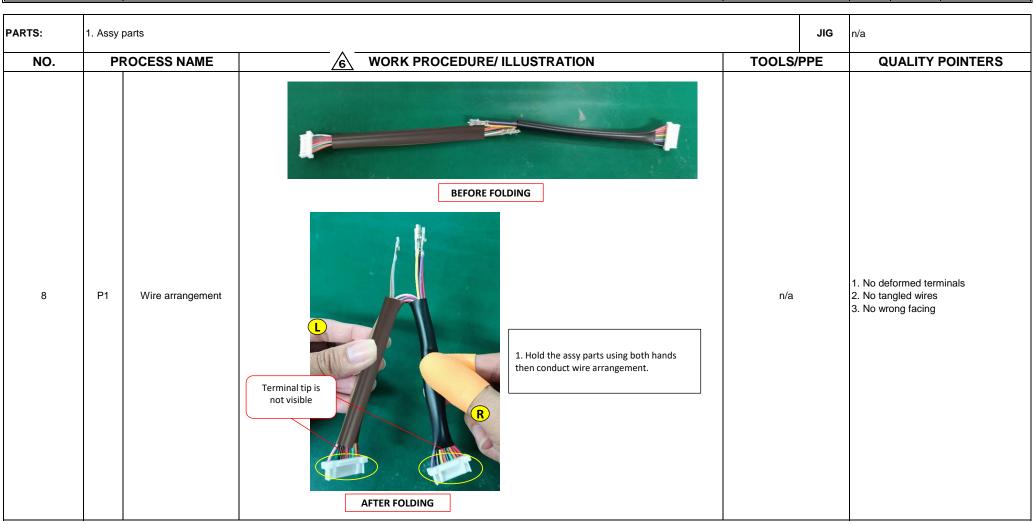


TS:	1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTER
7	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	3. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.	N/A	Terminal tip must be visible  Document References:  1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.  1. No deformed terminals 2. No tangled wires 3. No wrong facing

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				WORK INSTR	UC.	TION	WORK INSTRUCTION								
NEC	Process Name/Title:	Title: TAPING ASSEMBLY PROCESS Validity Date:									n/a				
	Model Code/Part Number:	400B	1	75N241-0040		Customer:	TRJ		Document No.:		WI-ENG-I	PDE-093			
	Purpose:	☐ PI	ROTOTYI	PE .		PRE-LAUNCH	MASSPRO		Revision No.:	6	Page No.:	7 of 14			



i <del>-</del>										
				NSTRUCTION		Effectivity Date:				y 24, 2023
		Process Name/Title:		PING ASSEMBLY PROC		Validity Date:				n/a
		Model Code/Part Number:	400B / 75N241	<b>-0040</b> Customer:	TRJ	Document No.:			WI-ENG	-PDE-093
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		6	Page No.:	8 of 14
PARTS:	1. Con	nector 1746872-1 (B)					JIG	1. Insertic	on jig	
NO.		PROCESS NAME	WOR	RK PROCEDURE/ ILLUSTRA	ATION	TOOLS/	PPE	C	UALITY	POINTERS
9	P1	Connector setting to insertion jig 1746872-1 (B)	INSERTION JIG  Press	Upper guide Upper button CONNECTOR ORIEI	and insert to insertion jig uisng right	N/A		2. No wro 3. No wro 4. No dar CON	NLOCK  CONNECTO  S872-1 (B)  cant reminded contains of the con	HALF-LOCKED OR ILLUSTRATION NG 1376675-1 (B)

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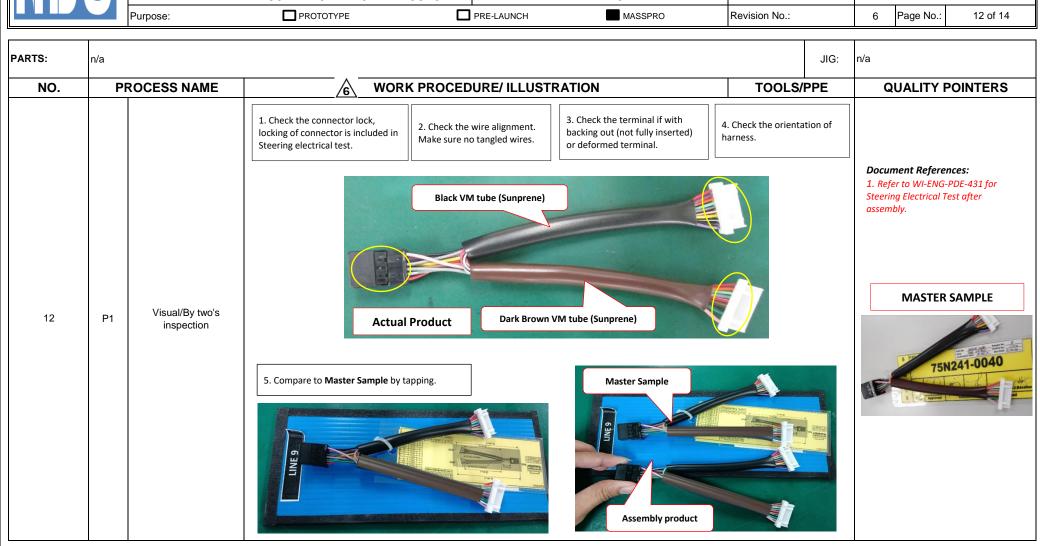
2. Check the connector before insertion.

			WORK INSTRU	JCTION		Effectivity Date:	February 24, 2023
		Process Name/Title:	TAPING A	SSEMBLY PR	OCESS	Validity Date:	n/a
		Model Code/Part Number:	400B / 75N241-0040	Customer:	TRJ	Document No.:	WI-ENG-PDE-093
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6 Page No.: 9 of 14
	1						1
PARTS:	1. Assy	parts				JIG	1. Insertion jig
NO.		PROCESS NAME	WORK PRO	CEDURE/ ILLUS	TRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	Wire insertion to Connector 1746872-1 (B)	INSERTION SEQUENCE FROM LEFT  2ND ROW  1ST ROW  1ST ROW  1. Insert first the wires from Black VM tube ( R wire and insert to terminal slot 1 using right process for Y-V-B wires.  Note: Follow the insertion sequence based or stated above.	BLACK VM TUB  BLACK VM TUB  GHT)  R  Sunprene). Hold the at hand. Repeat the	1 130 130 130 130		1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  Important reminders/Note/s:  1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.  2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.  Do not exert extra force. 3. Please hold the wire near terminal during insertion.  Document reference/s:  1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

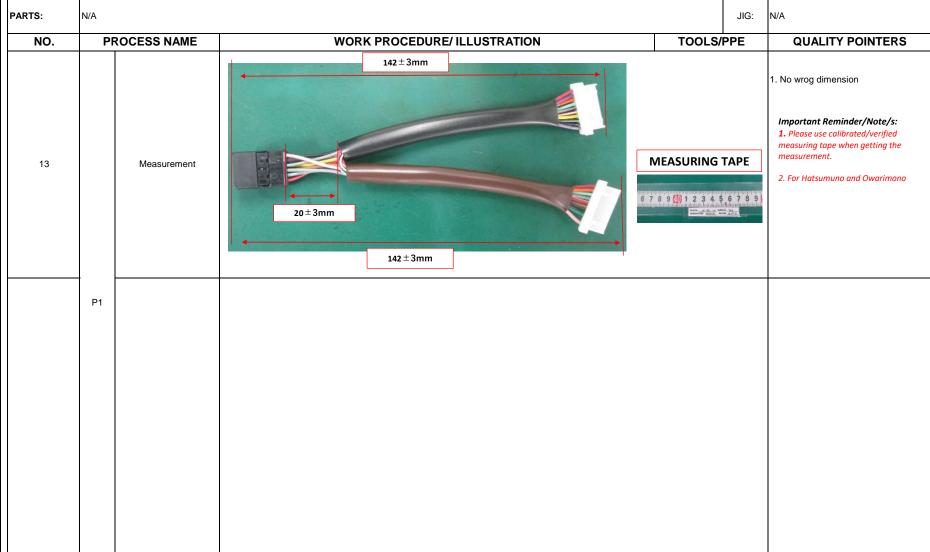
				WORK INSTRUC	TION		Effectivity Date:			February	24, 2023
		Process Name/Title:		TAPING AS	SEMBLY PROC	ESS	Validity Date:			n/	а
		Model Code/Part Number:	400B /	75N241-0040	Customer:	TRJ	Document No.:			WI-ENG-F	PDE-093
		Purpose:	PROTOTYP	E	PRE-LAUNCH	MASSPRO	Revision No.:		6	Page No.:	10 of 14
PARTS:	1. Assy	parts						JIG	1. Insert	tion jig	
NO.	ı	PROCESS NAME		WORK PROCE	DURE/ ILLUSTRA	TION	TOOLS/	PPE	Q	UALITY P	OINTERS
10	P1	Wire insertion to Connector 1746872-1 (B) (Continuation)			4. Hold the Gusing right havires.	wire and insert to terminal slot 7 and. Repeat the process for GR-P the insertion sequence based on	n/a		2. No will 3. One to 4. No will 5. No de 6. No sto 1. Auto the untermining the following street after after after after after 1. Ref Inspections 1. Ref Inspections 2. Ref Steering proce 3. Ref	nit if once enco nal, difficulty of ocked connecta ike sure wires weed. Conduct Pro- insertion. In the exert extra from ase hold the ward insertion. Cument reference for to GL-PRO- cition Standard for to WI-ENG- ing Navigation	of parts ion inal inal inal inal inal inal inal ina

				<b>WORK INSTRU</b>	CTION		Effectivity Date:		I	February 2	24, 2023
		Process Name/Title:		TAPING AS	SEMBLY PRO	CESS	Validity Date:			n/a	l
		Model Code/Part Number:	400B /	75N241-0040	Customer:	TRJ	Document No.:		,	WI-ENG-P	DE-093
		Purpose:	PROTOTYPE	С	PRE-LAUNCH	MASSPRO	Revision No.:		6 Pa	age No.:	11 of 14
	1	1							1		
PARTS:	1. Assy	parts						JIG	n/a		
NO.	P	ROCESS NAME	<u>6</u>	WORK PROCE	EDURE/ ILLUSTR	RATION	TOOLS/I	PPE	QU	ALITY P	OINTERS
11	P1	Wire Arrangement	Double lock in upwar	1. Hold wire property of the control	d the harness using both properly to avoid tangled  e lock in upward position  RECT FACING	hands. Arrange the	n/a			ng orientati gled wires	on of connector

			WORK INSTRU	UCTION		Effectivity Date:	Effectivity Date: February 24, 2			
Process Name/Title:			TAPING AS	SSEMBLY PRO	CESS	Validity Date:		n/	a	
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					WORK INSTR	UC.	TION			E	ffectivity Date:			February :	24, 2023
		Process Name/Title:	TAPING ASSEMBLY PROCESS						٧	Validity Date:		n/a			
		Model Code/Part Number:	400B	1	75N241-0040		Customer:	TR	J		Document No.:		WI-ENG-PDE-093		
		Purpose:	□P	ROTOTY	PE		PRE-LAUNCH		MASSPRO	R	evision No.:		6	Page No.:	13 of 14
		•											1		
PARTS:	N/A											JIG:	N/A		
NO.	Р	ROCESS NAME			WORK PRO	CED	URE/ ILLUS	TRATION			TOOLS/	PPE	C	UALITY P	OINTERS



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Process Name/Title:	Process Name/Title: TAPING ASSEMBLY PROCESS								
Model Code/Part Number: 400B /	75N241-0040 Customer: TR	J Document No.:	WI-ENG-PDE-093						
Purpose: Prototype	PRE-LAUNCH	MASSPRO Revision No.:	6 Page No.: 14 of 14						
			<u> </u>						
PARTS: n/a		JIG	n/a						
QUALITY CHECKPOINTS									
75N241-0040									
			4 300						
1. Check the connector lock, should be unlock.									
	Black VM Tube	(Sunprene)							
	Dark Brown VM tube (Sunprene)								
<ul><li>3. Check the orientation of harness.</li><li>4. Check if no missing parts.</li></ul>	5. Check the terminal if with backin (no fully inserted) or deformed terr	- I	er sample.						