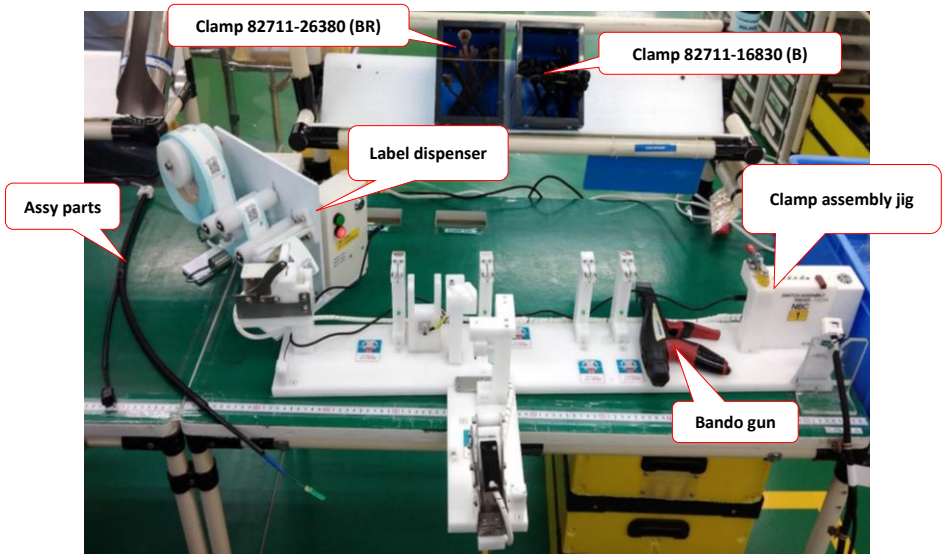
	WORK INSTRUCTION			Effectivity Date:	April 24, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	780B / 7R0103-7023A	Customer: TRMX	Document No.:	WI-ENG-PDE-542C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	1 of 10

PARTS:	1. Assy parts; Clamp 82711-26380 (BR); Clamp 82711-16830 (B)	JIG:	1. Clamp assembly jig 2. Label dispenser

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out	**Table Lay-out**  	**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. BANDO GUN	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
04/24/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a
10/07/22	2	Improve quality pointers: Reminders/notes and references in process no.2,3,5 and 6 due to document improvement. Work procedure/illustration in process no.5 - visual/by two's inspection.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
07/27/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
07/26/22	0	Initial issue QR code label 7V4020-0020 direction	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
J. Loterte	C. Villanueva	A. Arañes	n/a
Est. Date:	July 26, 2022		

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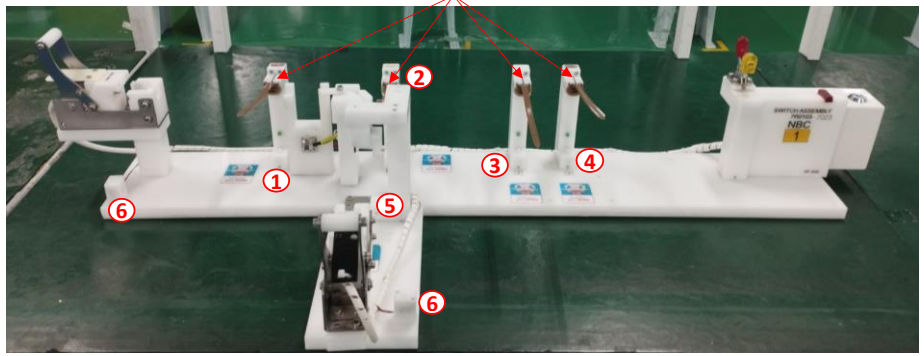
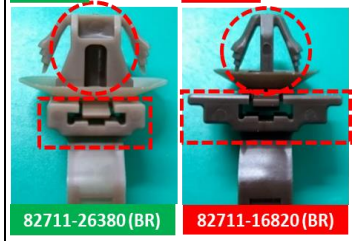
	Model Code/Part Number:	780B / 7R0103-7023A	Customer: TRMX	Document No.:	WI-ENG-PDE-542C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	2 of 10

PARTS:	1. Assy parts 2. Clamp 82711-26380 (BR) [4pcs.]	**JIG**	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting	 82711-26380 (BR)  1. Get 2pcs. of clamp **82711-26380 (BR)** using right hand and set to clamp location **1 and 2** using both hands. 2. Get 2pcs. of clamp **82711-26380 (BR)** using right hand and set to clamp location **3 and 4** using both hands.	n/a	***Important reminders/Note/s:*** ***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.*** 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts BAND CLAMP ILLUSTRATION GOOD / NG  82711-26380 (BR) / 82711-16820 (BR)

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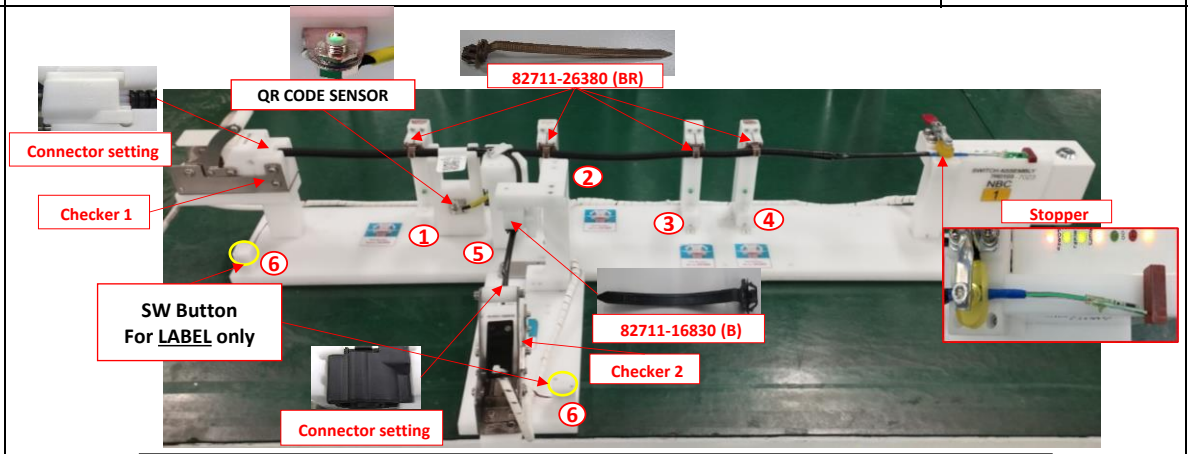
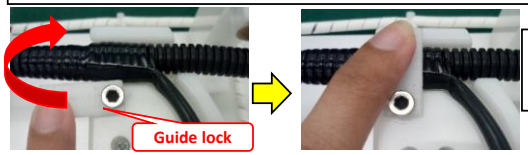
	Model Code/Part Number: 780B / 7R0103-7023A	Customer: TRMX		Document No.:	WI-ENG-PDE-542C	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 3 of 10

PARTS:	1. Assy parts 2. Clamp 82711-16830 (B)	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting (Continuation)			



3. Hold the assy parts and then set to jig. ***(See above picture for correct setting).*** First, set the connector **6189-1142 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. *(See below illustration for Y-Taping lock.)* Second, set the **PCB** to stopper jig and push down the toggle clamp. Last, set the connector **6189-1161 (B)** to **Checker 2** then push the checker fixture for continuity checking.



4. Using left index finger, push the guide lock to lock the Y-taping portion.

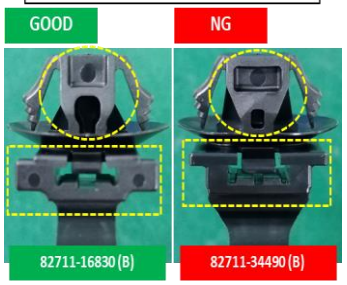
5. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **5** using both hands.

6. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

Important reminders/Note/s:
1. Make sure no gap between stopper and PCB

1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

BAND CLAMP ILLUSTRATION



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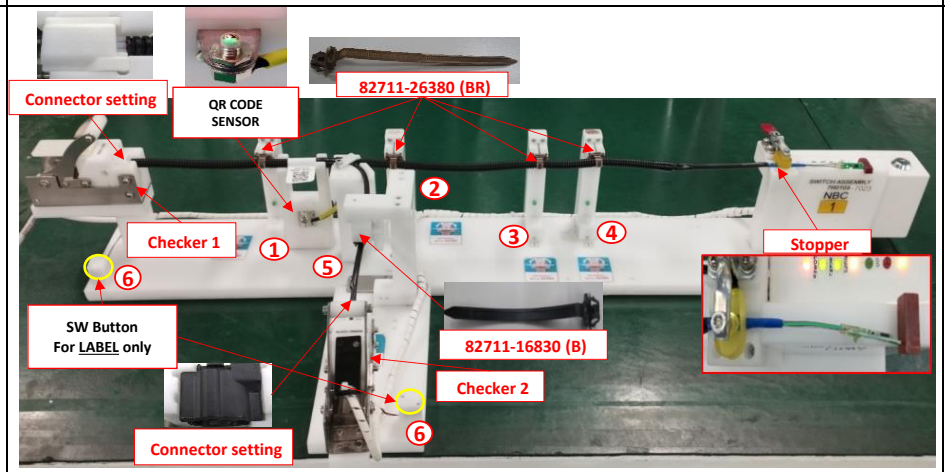
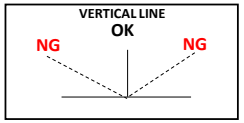
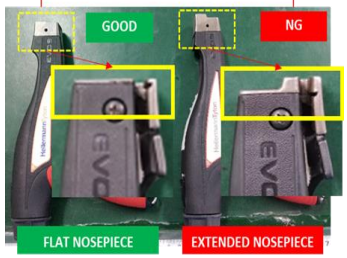
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Part Number: 780B / 7R0103-7023A	Customer:	TRMX	Document No.:	WI-ENG-PDE-542C	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.: 4 of 10

PARTS:	1. Assy parts	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	 1. Initially tighten the band clamp on clamp location **1, 2, 3, 4, and 5** using both hands. 2. Get the Bando Gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was **ON**. 3. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was **ON**.  4. Cut the band clamp on clamp location **3** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **4** was **ON**. **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4**	BANDO GUN 	 ***Important reminders/Note/s:*** ***1. Make sure no gap between stopper and PCB*** 1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig 6. No wrong use of bando gun BANDO GUN ILLUSTRATION  NO WRONG USE OF BANDO GUN

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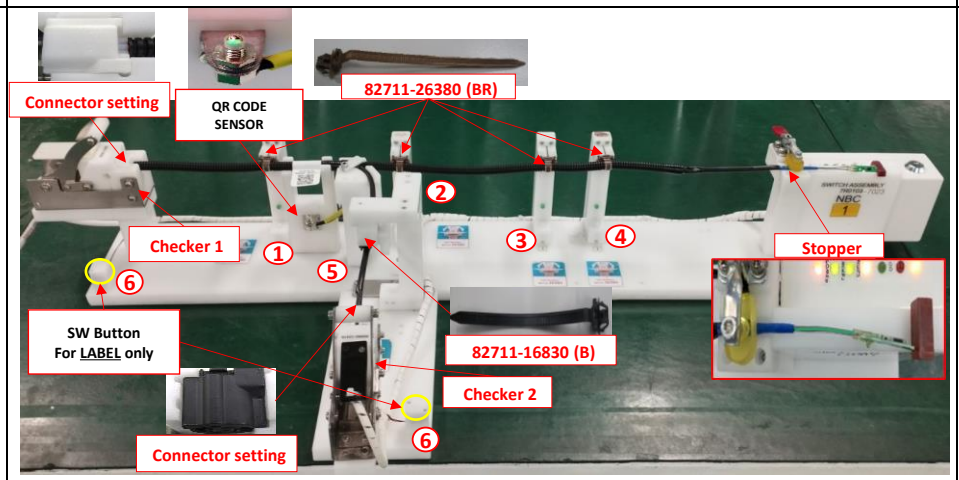
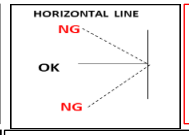
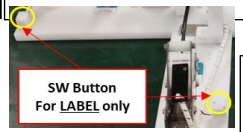
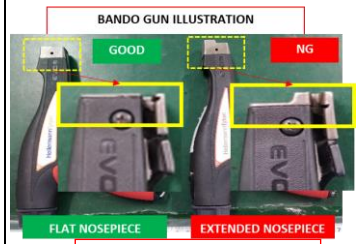
	Model Code/Part Number:	780B / 7R0103-7023A	Customer: TRMX	Document No.:	WI-ENG-PDE-542C	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.: 5 of 10

PARTS:	1. Assy parts	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly (Continuation)	 5. Cut the band clamp on clamp location **4** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **5** was **ON**.  **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.** **For: ø5 - 1~2, ø7 - 3~4** 6. Cut the band clamp on clamp location **5** using both hands. *(See below illustration)*. Press the **SW button** after cutting of band clamp. Continue on label attachment *(Refer to next page for label attachment procedure)* **BAND CLAMP CUT POSITION FOR 82711-16830 (B)** 7. For label attachment, **label sensor** will beep/buzz if detects the **label code**. After attachment, press the **SW button** using both index finger **(same timing). Go** sound will be heard.  8. Conduct **POINT CHECKING** before removing the harness from jig.	**BANDO GUN** 	 ***Important reminders/Note/s:*** ***1. Make sure no gap between stopper and PCB*** 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts  **NO WRONG USE OF BANDO GUN**

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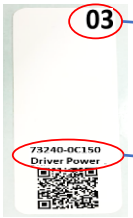
	Model Code/Product Number:	780B / 7R0103-7023A	Customer: TRMX	Document No.:	WI-ENG-PDE-542C	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.: 6 of 10

PARTS:	1. Assy parts 2. Label 7V4020-0020	JIG	1. Clamp Assembly jig 2. Label Dispenser

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Label attachment		n/a	1. No bubbles 2. No damage 3. No peel off 4. No wrong use of label 5. No missing parts 6. No loose attachment 7. No wrong usage of label

Model	Items	Item Name
7R0102	73240-0C140	Driver Manual
7R0103	73240-0C150	Driver Power
7R0104	73240-0C160	Driver PWR-MEM
7R0105	73230-0C170	Passenger Manual
7R0106	73230-0C180	Passenger Power



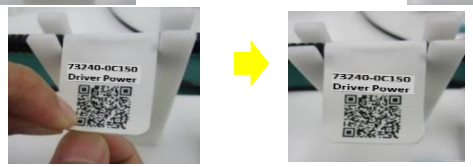
Model code

Item no. & name

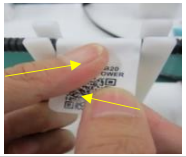
1. Get the label.
Note: Check the model code, item no. & name

2.Align the end part of label in the jig.

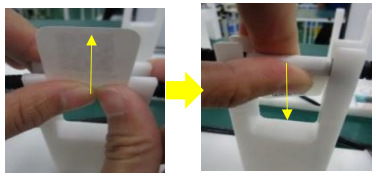
3.Fold the center part of the label



4. Align both end part of label .



5.After alignment , Press the label with both fingers .



6. Press the label upside down using finger.

Acceptable overlap
0~1mm

GOOD

NG

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label

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	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3
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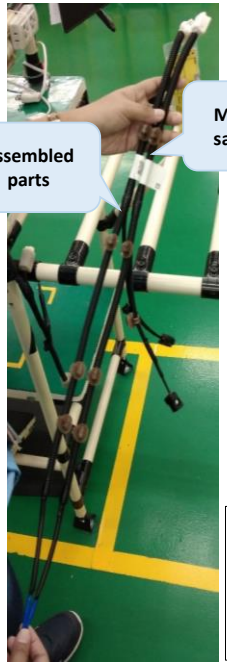
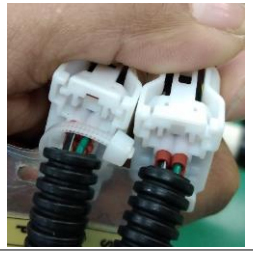
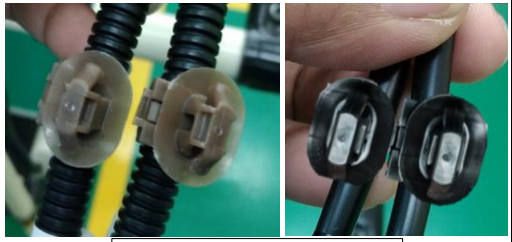
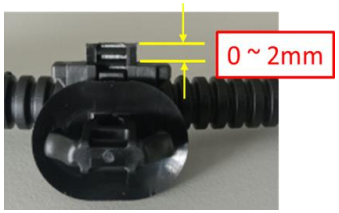
PARTS:	1. Assy parts	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P3	Visual/By two's inspection	 1. Conduct alignment of harness **(Master sample sample vs. assembled parts)** using both hands.  2. Check the **terminal, connector lock** condition and **insertion.**  3. Check the **presence of ALL clamp attachment.** 4. Check the **presence and condition of Barcode.**		**MASTER SAMPLE** 1. No skip process  **Important reminders/Note/s:** ***1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.***

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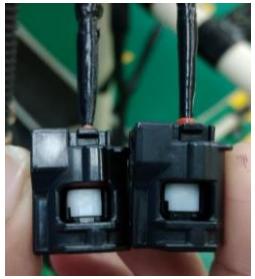
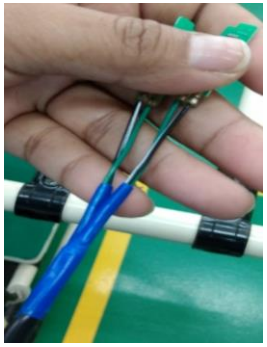
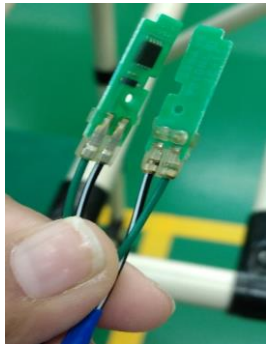
PARTS:	1. Assy parts	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P3	Visual/By two's inspection (Continuation)	 5. Check the **connector lock** condition, **insertion and taping condition.** 6. Check the **presence and condition of tape.**   7. Check the **tape color, taping condition and PCB appearance.**		**MASTER SAMPLE** 1. No skip process

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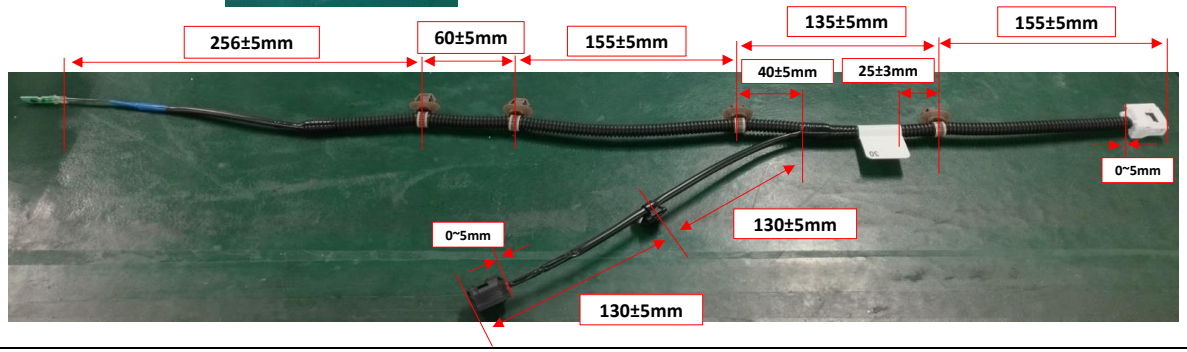
PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P3	Measurement	MEASURING TAPE *Note: Please use calibrated/verified measuring tape when getting the measurement.* 		***Important reminders/Note/s:*** ***1. FOR HATSUMONO AND OWARIMONO*** 1. No wrong dimension

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PARTS:	n/a	**JIG**	n/a

⚠3 QUALITY CHECKPOINTS

1 NO UNLOCKED/ HALF LOCKED CONNECTOR

2 3 4 5 6 NO MISSING CLAMP

7 CORRECT FACING OF CLAMP

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