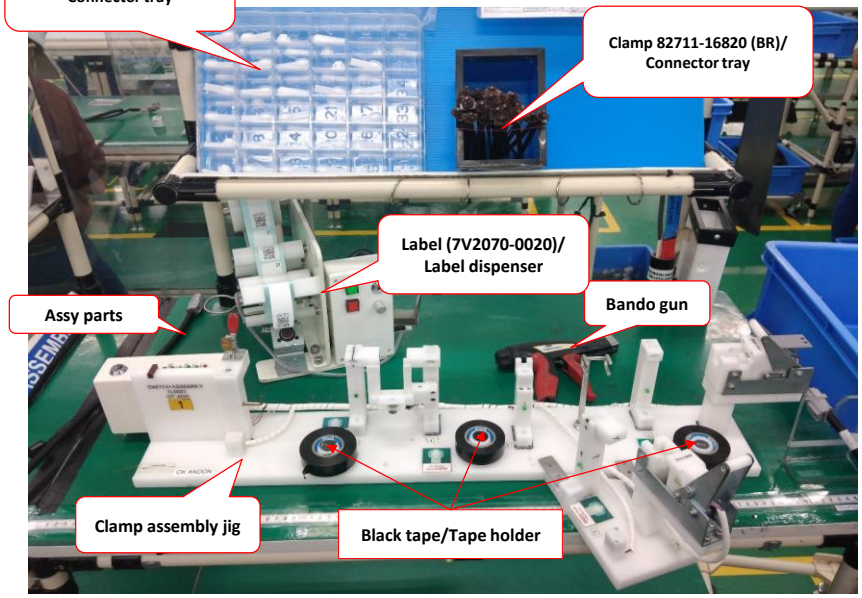
	WORK INSTRUCTION			Effectivity Date:	November 25, 2021		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number: 010B / 4 7L0031-7023	Customer:	TRQSS	Document No.:	WI-ENG-PDE-197C		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.:	1 of 8

PARTS:	1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-16820 (BR); Label (7V2070-0020); Black tape [3pcs.]	JIG:	1. Clamp assembly jig 2. Label Dispenser

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	4 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.	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
11/25/21	4	Change part number from 7L0031-7022 to 7L0031-7023 due to additional quantity of clamp 82711-52090 (W). Improve work procedure and illustration. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
06/03/21	3	Removal of validity date and apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
11/21/20	2	Transfer process owner from Production (WI-PRO-ASY-043A) to Engineering WI-ENG-PDE-197A; Apply some improvements; update pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 10, 2017		

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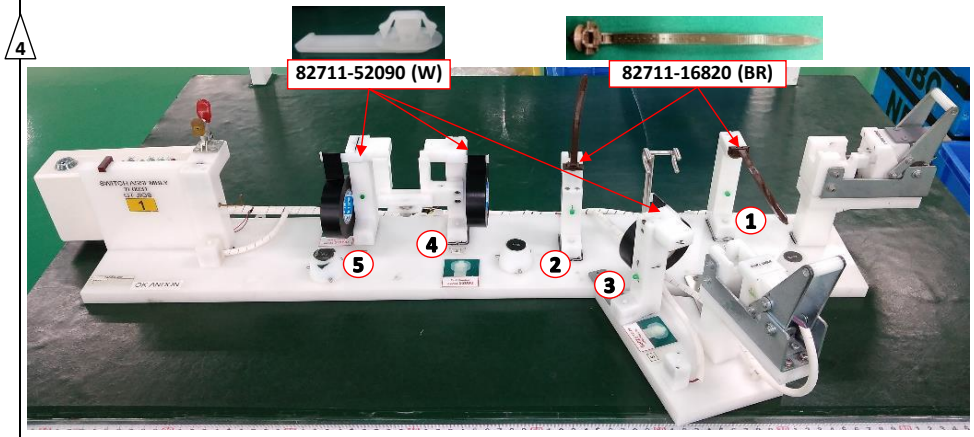
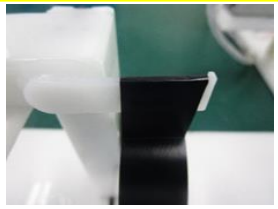
	WORK INSTRUCTION			Effectivity Date:	November 25, 2021		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	010B / 4 7L0031-7023	Customer: TRQSS	Document No.:	WI-ENG-PDE-197C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.:	2 of 8

PARTS:	1. Clamp 82711-52090 (W) [3pcs.] 2. Clamp 82711-16820 (BR) [2pcs.] 3. Black tape [3pcs.]	JIG	1. Clamp Assembly Jig

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting	4  1. Get 3pcs. of clamp **82711-52090 (W)** using both hands then attach to clamp location **5, 4, and 3** using both hands. 2. Get 2pcs. of clamp **82711-16820 (BR)** using both hands then attach to clamp location **2 and 1** using both hands. 3. Get the Black tape then initially attach to clamp location **5, 4 and 3** using both hands. ***Note:*** ***Please check the Clamp first before start of assembly to avoid wrong use of clamp.***	n/a	**STANDARD TAPING FOR CLAMP** One side tape under the clamp  1. No wrong use of clamp 2. No damaged clamp 3. No wrong clamp position 4. No wrong use of tape

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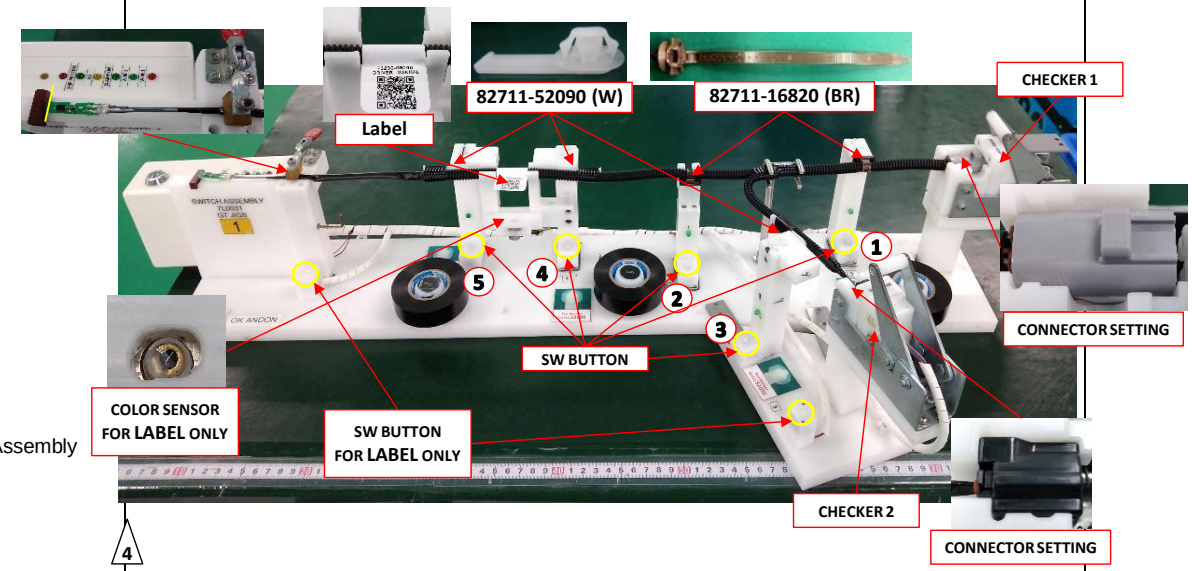
	Model Code/Part Number: 010B / 4 7L0031-7023		Customer: TRQSS	Document No.:	WI-ENG-PDE-197C
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4 Page No.: 3 of 8

PARTS:	1. Assy parts	**JIG**	1. Clamp Assembly Jig

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly	 4	n/a	 *Note: Make sure no gap between stopper jig 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

1. Get the assy parts and set into jig. ***(See above picture for correct setting).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector to **6189-1161 (B)** to **Checker 2** then pull the checker fixture for continuity checking. Last, set the end of **GR/BW hotmelted wire** together within the stopper then press by **Toggle clamp.** Continue if the sequence light in location **1** was **ON.**

2. Check if all **LED light** for **POWER ON, WIRE1, WIRE2 and CLAMP ON** was **ON.** If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.

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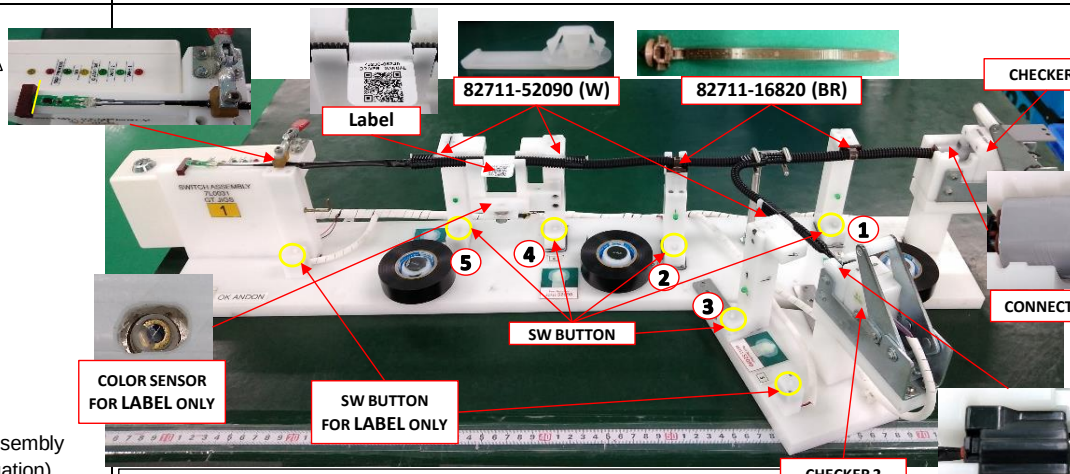
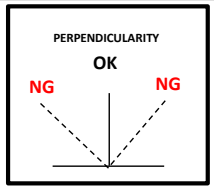
	Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:	n/a
	Model Code/Part Number: 010B / 4 7L0031-7023	Customer: TRQSS	Document No.:	WI-ENG-PDE-197C
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4 — Page No.: 4 of 8

PARTS:	1. Assy parts	**JIG**	1. Clamp Assembly Jig

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly (Continuation)	 3. Initially tighten the band clamp on location **1 and 2** using both hands. 4. Get the bando gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cut. Continue if the sequence light on clamp location **2** was **ON.** Fixed setting of band clamp cutter: 3 ~ 4 BANDO GUN POSITION ON CLAMP LOCATION 1 Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4 GOOD NG BANDO GUN ALIGNMENT  	BANDO GUN 	 *Note: Make sure no gap between stopper jig 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

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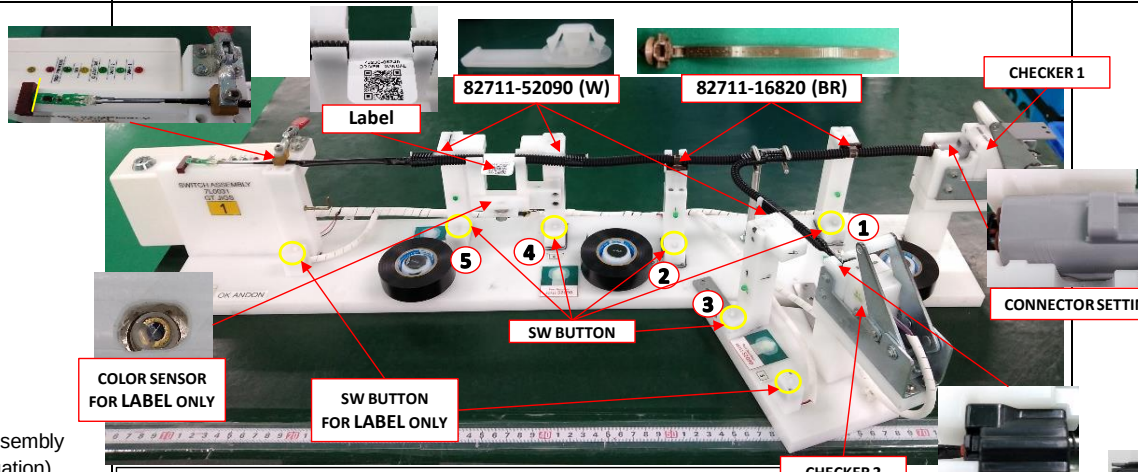
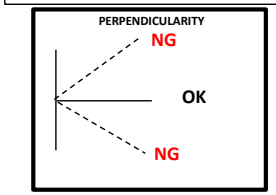
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model Code/Part Number: 010B / 4 7L0031-7023	Customer: TRQSS	Document No.:	WI-ENG-PDE-197C
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4 — Page No.: 5 of 8

PARTS:	1. Assy parts	**JIG**	1. Clamp Assembly Jig

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly (Continuation)	 5. Cut the band clamp on location **2** using both hands. Press the **SW button** after cut. Continue if the sequence light on clamp location **3** was **ON.** BANDO GUN POSITION ON CLAMP LOCATION 2 Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4 Fixed setting of band clamp cutter: 3 ~ 4 BANDO GUN ALIGNMENT 	BANDO GUN 	 *Note: Make sure no gap between stopper jig 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

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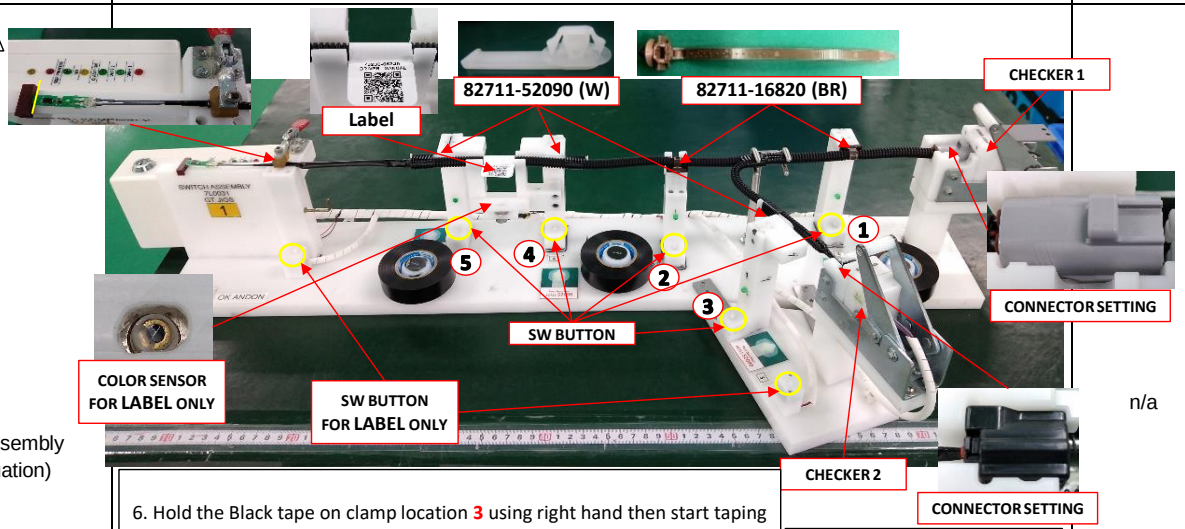
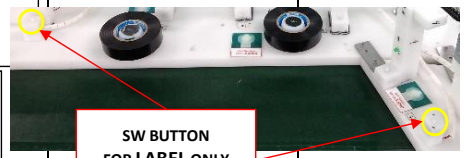
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4 Page No.: 6 of 8

PARTS:	1. Assy parts 2. Black tape	**JIG**	1. Clamp Assembly Jig

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly (Continuation)	 6. Hold the Black tape on clamp location **3** using right hand then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue if the sequence light on location **4** was **ON.** 7. Hold the Black tape on clamp location **4** using right hand then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue if the sequence light on location **5** was **ON.** 8. Hold the Black tape on clamp location **5** using right hand then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue on label attachment *(Refer to next page for label attachment procedure)* 9. For label attachment, **color sensor** will light if detects the **label code**. After attachment, press the **SW button** using both index finger **(same timing). Go** sound will be heard. 10. Conduct **POINT CHECKING** before removing the harness from jig. 	n/a	 *Note: Make sure no gap between stopper jig 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

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	Model Code/Part Number: 010B / 4 7L0031-7023		Customer: TRQSS	Document No.:	WI-ENG-PDE-197C		
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH ■ MASSPRO	Revision No.:	4	Page No.:	7 of 8

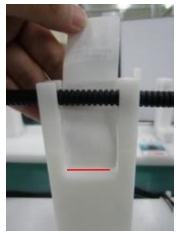
PARTS:	1. Assy parts 2. Label 7V2070-0020	JIG	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	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

Model	Item No	Item Name
7L0030	73230-06750	Passenger Manual
7L0031	73230-06740	Driver Manual
7L0032	73230-06B20	Passenger Power
7L0033	73230-06760	Driver Power

Model code

Item no. & name



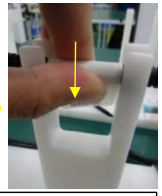
1. Get the label
Check the model code, item no. & name

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.

GOOD

Acceptable overlap
0~1mm

NG

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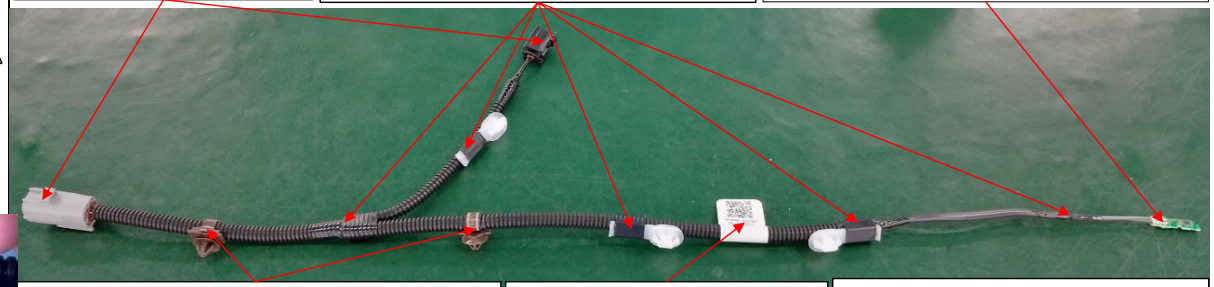
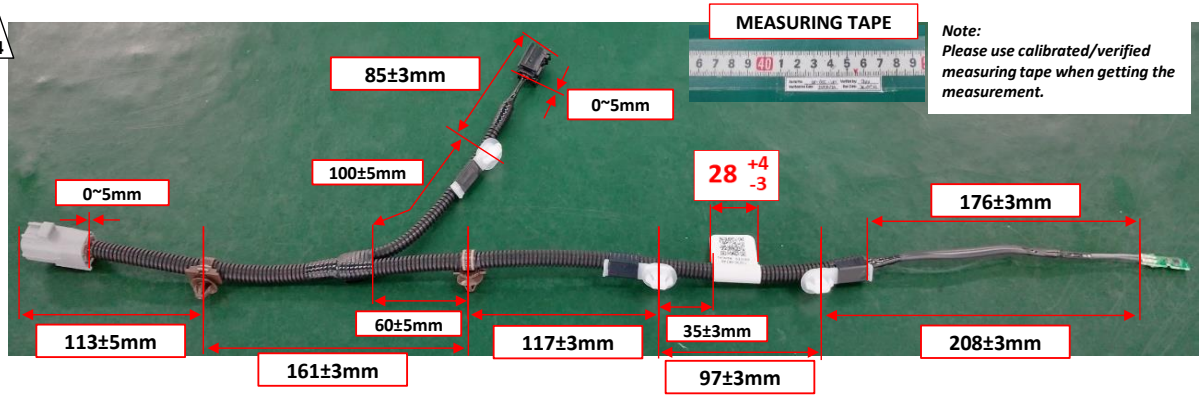
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	4 Page No.: 8 of 8

PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P3	Visual/By Two's Inspection	4  3. Using a steel rule, check if the band cut measurement is within the required dimension **(0~2mm)** and should not exceed the maximum value. 4. Check the presence of label. 6. Compare to Master Sample ***Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy.***		**Master Sample**
6		Measurement	4  ***Note: Please use calibrated/verified measuring tape when getting the measurement.***		***NOTE: FOR HATSUMONO AND OWARIMONO*** 1. No wrong dimension

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