				WORK	INSTRUC	TION			Effe	ctivity Date:		Apr	il 28, 2023	
			Process Name/Title:	TA	APING ASS	SEMBLY PRO	CESS		Valid	dity Date:			n/a	
N			Model Code/Part Number:	400B / 75N24	12-0020	Customer:	TR	J	Doc	ument No.:		WI-EI	NG-PDE-094	
			Purpose:	PROTOTYPE		PRE-LAUNCH	MASS	PRO	Rev	ision No.:	6	Page No.:	1 of	11
PARTS:	1		ector PBVP-08V-S (W) ector PBVP-10V-S (W)								JIG:	1. Insertion jig		
N	0.	Р	ROCESS NAME	WO	RK PROCE	DURE/ ILLUST	RATION			TOOLS	S/PPE	QUA	LITY POINT	ERS
	1	P1	Connector setting to insertion jig PBVP-08V-S (W) PBVP-10V-S (W)	1 2 Insertion Jig	Guide lock Unlock Button 1. Get the conn Repeat the production		2. Press button of finger. Y	2 o insertion jig	2 2 v	Safety Insert of weap personal prequipment of the personal preserved in the personal preserved i	r prescribed rotective t during oves, finger etc.) reping and always e 5's. rote borohibited. rote le, inform r Assistant Line Leader corrective	1. Use the prov 2. No wrong us 3. No wrong or 4. No damaged	ientation of con	
04/28/23	6	Inclusion	of quality checkpoints; standard	dize VM tube (sunprene) term	•		J. Loterte	C. Villanueva	A. Arañes	n/a				
10/07/22	5	Improve \	Work procedure/illustration on p	process no.11-Visual/by two's inspect	tion.		M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
08/09/22	4		process illustration. Merged P1 a	and P2 due to the process improven Strip Length Tolerance.	nent. Additional q	uality pointers in wire i	nsertion D.Castillo	J. Loterte	C. Villanueva	a A. Arañes				
03/22/21		Standard	ization for Plastic Parts). Chang	with color standardization for plastic p ge from 2x pulling to Pull-Push-Pull-P dard for Coupler Insertion (GL-PRO-/	ush insertion qua	ality pointers. Remove	cycle D.Castillo	C.Villanueva			J. Loverte	Joseph for C. Villanueva	A. Aranes	n/a
Eff. Date	Rev. No			Details of Change			Revised	Checked	Approved	Noted	Established D	ate: Octol	per 9, 2019	

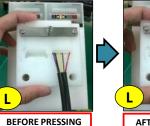
				WORK INSTRU	JCTION		Effectivity Date:		April 28,	2023
		Process Name/Title:		TAPING AS	SSEMBLY PROCE	SS	Validity Date:		n/a	
		Model Code/Part Number:	400B	/ 75N242-0020	Customer:	TRJ	Document No.:		WI-ENG-PI	DE-094
		Purpose:	☐ PR	OTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		6 Page No.:	2 of 11
							<u> </u>		<u>.l </u>	
PARTS: 6		S 0.3 B/W L=208±2mm; BR in VM tube (Sunprene) Ø6.5		R/W L=208; GR L=130±2mm; l	_G L=208±2mm; OR L=208	-2mm; R/L L=208±2mm		JIG	1. Insertion jig	
NO.	Р	ROCESS NAME		WORK PROC	EDURE/ ILLUSTRAT	ION	TOOLS/F	PPE	QUALITY PO	DINTERS
2	P1	Wire insertion to Connector PBVP-08V-S (W)	1. Get the R/W-GR-L	E BLACK/WHITE wire using right had G-OR-R/L. ow the insertion sequence based o	208 130 208	Note: Please hold the wire near terminal during insertion. 5 6 7 8 GR LG OR R/L 130 208 208 208	STEERIN NAVIGATI CONTROL	ON	1. Use provided jig per 2. No wrong usage of 3. One by one insertion 4. No wrong insertion 5. No deformed termina 6. No stuck of termina 6. No stuck of termina 6. No stuck of terminal 6. No stuck o	parts on nal al tip rs/Note/s: ire near rtion. are properly ull-Push-Pull- orce. DE-044 for ontroller Y-028 for Pull-
3	<u>/6</u>	Wire insertion to Green VM tube (Sunprene) Ø6.5 L=85±2mm				1. Hold the wires using left hand, get the Green Sunprene tube Ø6.5 L=85±2mm using right hand then insert the wires.	N/A		No wrong usage of No deformed terming No tangled wires	

				WORK INSTRU	ICTION		Effectivity Date:			April 28,	2023
		Process Name/Title:		TAPING AS	SEMBLY P	ROCESS	Validity Date:			n/a	
		Model Code/Part Number:	400B /	75N242-0020	Customer:	TRJ	Document No.:			WI-ENG-PI	DE-094
		Purpose:	PROTOTYF	E	PRE-LAUNCH	MASSPRO	Revision No.:		6	Page No.:	3 of 11
PARTS:		S 0.3 V L=130±2mm; B L=13	30±2mm; Y L=130±2n	nm; GR/B L=130±2mm; WORK PROC		STRATION	TOOLS/	JIG PPE	1. Insertic	on jig	DINTERS
4	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the GR/B-R. Ch	NCE FROM LEFT TO RIGHT SOCIONAL X X X X X X X X X X X X X X X X X X X	1 2 3 V B X 130 130 N	Wire facing 4	STEERIN NAVIGAT	IG ION	2. No wro 3. One by 4. No wro 5. No def 6. No stu Import 1. Plea termin 2. Mak inserte Push aj Do not Docum 1. Refe Steering procedu 2. Refer Push pr 3. Refer	fter insertion. exert extra for exert exert extra for exert exert extra for exert exert exert extra for exert exer	parts on nal al tip rs/Note/s: vire near ertion. are properly ull-Push-Pull orce. res: PDE-044 for controller SY-028 for Pull-

				WORK INSTRU	JCTION		Effectivity Date:			April 28	, 2023
		Process Name/Title:		TAPING A	SSEMBLY PRO	CESS	Validity Date:			n/a	a
	7	Model Code/Part Number:	400B /	75N242-0020	Customer:	TRJ	Document No.:			WI-ENG-P	'DE-094
		Purpose:	PROTOTY	PE	PRE-LAUNCH	MASSPRO	Revision No.:		6	Page No.:	4 of 11
PARTS: 6	1. Blacl	k VM tube (Sunprene) Ø8 L=	-85±2mm					JIG	1. Insert	ion jig	
NO.	F	PROCESS NAME		WORK PRO	CEDURE/ ILLUSTF	RATION	TOOLS/I	PPE	Q	UALITY P	POINTERS
5	Δ	Wire insertion to Black VM tube (Sunprene) Ø8 L=85±2mm		ng left hand, get the Black t2mm using right hand the		3. Remove the 1st connector with inserted wires (With Green VM tube (Sunprene). Check the wire insertion condition. Second connector with	N/A		1. No wr 2. No de 3. No tar Docum 1. Refe	rong usage o eformed term ngled wires nent Reference er to GL-PRO-A tion Standard f	ces: ASY-025 for

6 Wire insertion to assy parts

P1



BEFORE PRESSING

1. Press the guide lock button using left thumb.

2. Hold the Black
Sunprene tube
using left hand,
and insert the
wires from Green
Sunprene tube
using right hand.

inserted wire is still on the jig.

1. No wrong use of parts N/A 2. No deformed terminal

3. No tangled wires

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			1	WORK INSTRU	CTION			Effectivity Date:			April 2	3, 2023
		Process Name/Title:		TAPING AS	SEMBLY P	ROCESS		Validity Date:			n/	a
		Model Code/Part Number:	400B /	75N242-0020	Customer:		TRJ	Document No.:			WI-ENG-	PDE-094
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH		MASSPRO	Revision No.:		6	Page No.:	5 of 11
PARTS:	1. Assy	parts							JIG	1. Inserti	on jig	
NO.	P	ROCESS NAME		WORK PROC	EDURE/ ILLU	STRATION		TOOLS/	PPE	QI	JALITY F	POINTERS
7	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Hold the B/W wire a R/W-LG-OR-R/L Check	1 V 130 R Is and insert to connector be k the wire after insertion ion sequence based on the	2 3 4 B B/W Y 130 208 130		8 9 10 OR R/L R 208 208 130 Pepeat the process on	STEERIN NAVIGAT CONTROL	ION	2. No wro 3. One b 4. No wro 5. No de 6. No stu Import 1. Plea termin 2. Mak inserte Push a Do not Docum 1. Refe Steering procedu 2. Refei Push pr 3. Refei Inspect insertio 4. Refei	se hold the al during in the sure wire. d. Conduct fter insertic exert extra the exert extra to WI-ENG g Navigation the exert of GL-PRO-cocedure. To GL-PRO-cion Standard in	of parts tion n ninal nal tip lers/Note/s: wire near sertion. s are properly Pull-Push-Pull- n. forcePDE-044 for Controller ASY-028 for Pull- ASY-025 for for connector

			W	ORK INSTRU	CTION		Effectivity Date:			April 28,	2023
		Process Name/Title:		TAPING AS	SEMBLY PROCE	SS	Validity Date:			n/a	
		Model Code/Part Number:	400B / 75	N242-0020	Customer:	TRJ	Document No.:			WI-ENG-P	DE-094
		Purpose:	☐ PROTOTYPE	1	PRE-LAUNCH	MASSPRO	Revision No.:		6 P	age No.:	6 of 11
PARTS:	1. Con	nector 1746872-1 (B)						JIG	1. Insertion	n jig	
NO.	l	PROCESS NAME		WORK PROCI	EDURE/ ILLUSTRA	TION	TOOLS/F	PPE	QU.	ALITY PO	DINTERS
7		Wire insertion to Connector PBVP-10V-S (W) (Continuation)	2. Press the unlock button using left hand and remove the harness from jig.		L	3. Hold the Assy parts using both hands and fold slowly. Check the wire insertion condition.	N/A		Term	ninal tip mu	st be visible
8	P1	Connector setting to insertion jig 1746872-1 (B)	Press Press BEFORE PRESSING	Visual reference Upper Guide Lock Unlock Button Lower Guide Lock AFTER PRESSING	then insert to inserting the control of the control	Note: Check the connector before insertion. 1746872-1 (B) using left hand on jig. nector orientation and lower guide lock using left ger. You will notice the holes that	N/A		2. No wror 3. No wror 4. No dam CONNECTO UNL Importai 1. Autom the unit if terminal,	orientation guse of conaged connections and connections and connections are connections and connections are connections and connections are connections and connections are connections are connections and connections are connections and connections are connections are connections are connected and connected are connected as a connected are connected are connected as a connected are connected are connected are connected are	EARANCE CHECK NG HALF-LOCKED rs/Note/s: use and replace utered bend insertion and

				٧	VORK INSTRU	JCTION		Effectivity Date:			April 28	8, 2023
		Process Name/Title:			TAPING A	SSEMBLY	PROCESS	Validity Date:			n/	'a
		Model Code/Part Number:	400B	/ 7	75N242-0020	Customer	r: TRJ	Document No.:			WI-ENG-I	PDE-094
		Purpose:	PROTO	OTYPE		PRE-LAUNG	CH MASSPRO	Revision No.:		6	Page No.:	7 of 11
PARTS: 1.	. Assy	parts							JIG	1. Inserti	on jig	
NO.	Р	ROCESS NAME			WORK PRO	CEDURE/ IL	LUSTRATION	TOOLS/	PPE	QI	JALITY F	POINTERS
9	P1	Wire insertion to insertion jig 1746872-1 (B)	1. Insert first the R wire and Repeat the pro	ne wires insert to cess for the insert to	RTION SEQUENCE FRO 1	M LEFT TO RIGHT 10 10 10 10 10 10 10 10 10 10 10 10 10	9 10 X X GR GR/B X X X 130 130 130 130 130 130 130 130 130 130			1. Use th 2. No wro 3. No wro 4. No wro 5. No de 6. No stu Import 1. Please termina 2. Mak insertee Push aj Do not 3. Autor the unit termina half-loc Docume 1. Refer Push pro 2. Refer	ne provided ong usage of ong orientation on insertio formed terminate of terminate of terminate of the orientation of terminate of the orientation	jig per model of parts tion of connector in ninal nal tip ers/Note/s: wire near sertion. s are properly Pull-Push-Pull-n. force. pose and replace ountered bend of insertion and or. ess: ASY-028 for Pull-

				WC	ORK INSTRU	UCTION		Effectivity Date:		T	April 28	, 2023
		Process Name/Title:			TAPING A	SSEMBLY PI	ROCESS	Validity Date:			n/a	а
		Model Code/Part Number:	400B	/ 75	N242-0020	Customer:	TRJ	Document No.:			WI-ENG-F	DE-094
		Purpose:	□ P	ROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		6	Page No.:	9 of 11
								•				
PARTS:		mbled parts er sample							JIG:	n/a		
NO.	Р	ROCESS NAME			WORK PRO	CEDURE/ ILLU	STRATION	TOOLS/	PPE	QI	JALITY P	POINTERS
11	P1	Visual/By Two's Inspection	lock, lockin is included electrical to		Make sure no	RODUCIS	3. Check the terminal if with backing out(not fully inserted) or deformed terminal. e) MASTER SAMPLE ASSEMBLY PRODUCT	4. Check the orientation harness.	n of	2. No Ta 3. No mis	ong facing o ngled wires ssing parts MASTER S ment Referent r to WI-ENG-F g Electrical Te	SAMPLE ALLEGA STATE OF THE STATE OF T

				WORK INSTRU	JCTION		Effectivity Date:			April 28,	2023
		Process Name/Title:		TAPING A	SSEMBLY PRO	OCESS	Validity Date:			n/a	
		Model Code/Part Number:	400B /	75N242-0020	Customer:	TRJ	Document No.:		١	WI-ENG-P	DE-094
		Purpose:	☐ PROTOTYP	E	PRE-LAUNCH	MASSPRO	Revision No.:		6 Pa	age No.:	8 of 11
PARTS:	N/A							JIG	Insertion Locking j	ı jig jig	
NO.	P	PROCESS NAME		WORK PRO	CEDURE/ ILLUS	TRATION	TOOLS/I	PPE	QUA	ALITY PO	DINTERS
9	P1	Wire insertion to insertion jig 1746872-1 (B) (Continuation)	GREEN VM TU	3. Insert the wires from (Sunprene). Hold the Br terminal slot 3 using rigi Note: Follow the insertic illustration stated above	rown wire and insert to ht hand. on sequence based on th	4. Hold the Gray wire and insert to terminal slot 9. Note: Follow the insertion sequence based on the illustration stated above.	n/a		1. Use prov 2. No wrong 3. One by c 4. No wrong 5. No defor 6. No stuck	g usage of one insertion g insertion rmed termin	parts on nal
10		Wire Arrangement			properly to avoid tangle Refer to below illustration and facing. GOOD ARRANGEMENT WIRES	on for Good wire arrangement	n/a		1. No wrong 2. No tanglo 3. No wrong	led wires	on of connector facing

		WORK INST	RUCTION		Effectivity Date:			April 28,	2023
	Process Name/Title:	TAPING	ASSEMBLY PROC	ESS	Validity Date:			n/a	
	Model Code/Part Number:	400B / 75N242-002	Customer:	TRJ	Document No.:			WI-ENG-P	DE-094
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		6	Page No.:	10 of 11
PARTS:	N/A					JIG:	N/A		
NO.	PROCESS NAME	WORK PR	OCEDURE/ ILLUSTR	ATION	TOOLS/	PPE	Q	UALITY P	DINTERS
12	Measurement	L=20 ± 3mm	L=142±3mm		Measuring	5 6 7 8 9	Impo 1. Ple measu	rong dimensic rtant Reminda ase use calibra uring tape whei urement.	er/Note/s: ed/verified

P1

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2. For Hatsumuno and Owarimono

W	ORK INSTRUCTION		Effectivity Date:	April 28, 2023
Process Name/Title:	TAPING ASSEMBLY PROCES	SS	Validity Date:	n/a
Model Code/Part Number: 400B / 7	5N242-0020 Customer:	TRJ	Document No.:	WI-ENG-PDE-094
Purpose: PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6 Page No.: 11 of 11
PARTS: 1. Assy parts	© QUALITY CHECKPOIN		JIG:	N/A
1.Check the connector lock.	2.Check the wire alignme sure no tangled wires. Black VM tube (Sunprene) 5.Check the terminal if without (not fully nserted) or de	Green VM tube (heck if no mising Sunprene)	CORRECT FACING
3.Check the orientation of harness.				