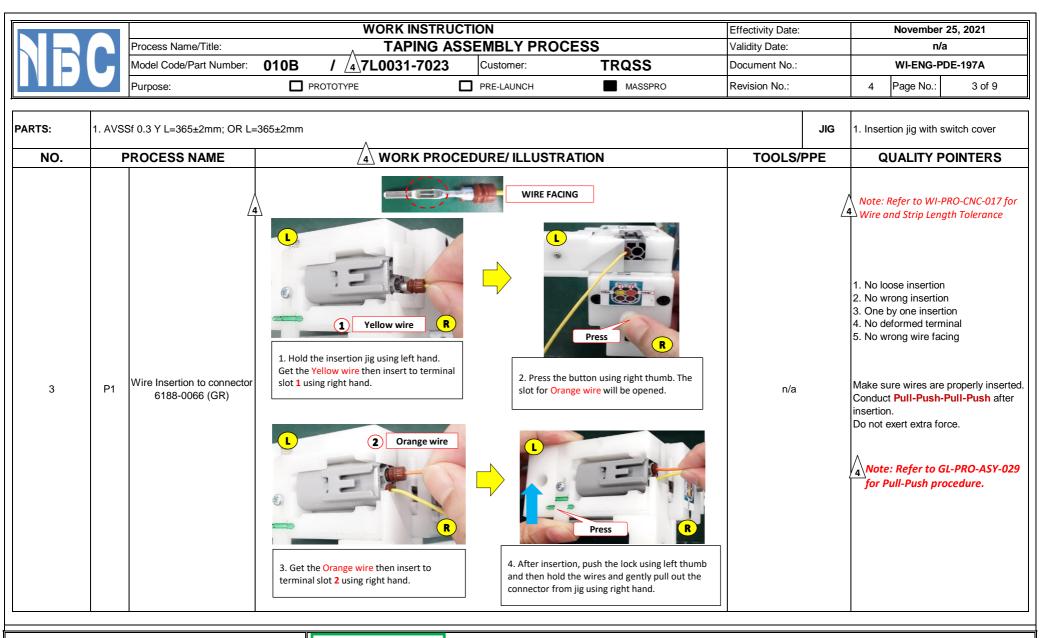
	_			WORK INS	STRUCTION			Effecti	vity Date:		November 25,	2021
		Process Name/Title:			IG ASSEMBLY PROC	ESS			y Date:		n/a	
		Model Code/Part Number:	010B	/ 47L0031-7023	Customer:	TRQSS		Docum	nent No.:		WI-ENG-PDE-	197A
		Purpose:	□PROT	ГОТҮРЕ	PRE-LAUNCH	MASSPRO		Revision	on No.:	4	Page No.:	1 of 9
PARTS: $\sqrt{\frac{4}{4}}$		OT ø5 L=158±3mm (no slit)			/ L=365±2mm; OR L=365±2mm W CP GR-B/W L=678±3mm witl				JIG:	2. Lockin	on jig with switch co g jig nal cover jig	ver
NO.		ROCESS NAME		4\WORK I	PROCEDURE/ ILLUSTR	ATION			TOOLS/PPE	0. 10	QUALITY POI	NTERS
1	P1	Table Lay-out	Connector 6188 Connecto Insertion jig A	AVSSF 0.3 Y L OR L=36	(no slit) Terminal cover jig M Lainser	Conne	Black COT \$\phi\$ 7 = 326±3mm (no slit)	Be s p p e ope	afety Instruction were to wear requirersonal protective equipment during ration (gloves, fing cots, etc.) Housekeeping Maintain and alwa practice 5's. ersonal things on the price is prohibite the it in your locke Alert level any trouble, infort e Assembly Assista ervisor or Line Lea mmediate correct action.	ys !	Refer to WI-PRO and Strip Length ssing parts/tools sess parts/tools	
		•		Revision History					Prepared by	Reviewed by	Approved by	Noted by
11/25/21 4	ENG-PD PRO-CN	E-197C). Improve work procedu IC-017 for Wire and Strip Length	ıre. Additional table n Tolerance)		p (82711-52090 (W)) (Refer to WI- g of wire tolerance (Refer to WI-	M. Catapang J. Loterte		vrañes			, . //	
06/03/21 3 11/21/20 2	Transfer	I of validity date and apply some process owner from Production ments; update pictures		3A) to Engineering WI-ENG-PI	DE-197A; Apply some	M. Catapang C.Villanue J. Loterte R. Peñalo:		krañes krañes	M. Catapang	J. Loterte	C. Vilfanueva	A. Arañes
Eff. Date Rev. No			Detai	ils of Change		Revised Reviewe	d Approved N	oted E	Est. Date:	July 10, 2017		

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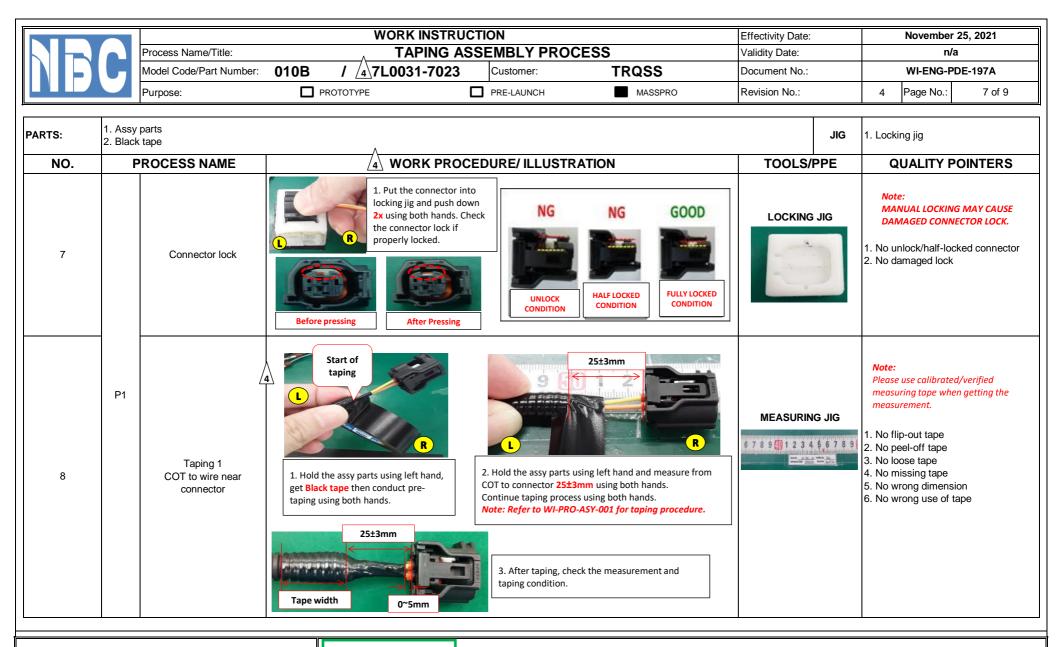
			WORK IN	STRUCT	ΓΙΟΝ		E	Effectivity Date:			November	r 25, 2021
		Process Name/Title:	, TAPII	IG ASS	SEMBLY PROCI	ESS	٧	/alidity Date:			n/	'a
		Model Code/Part Number:	010B / 4\7L0031-7	7023	Customer:	TRQSS	С	Document No.:			WI-ENG-P	PDE-197A
		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	R	Revision No.:		4	Page No.:	2 of 9
PARTS:	1. Conn	nector 6188-0066 (GR)							JIG	1. Inserti	on jig with:	switch cover
NO.	F	PROCESS NAME	WORK	PROCE	DURE/ ILLUSTRA	TION		TOOLS/I	PPE	QI	JALITY F	POINTERS
2	P1	Connector setting to insertion jig 6188-0066 (GR)	Insertion jig with switch cover Orange wire Yellow wire Visual reference Press 1. Press the lock using left hand.	insertion Note: Fol	INSERTION JG ORIENTATION Press Re connector 6188-0066 (con jig. Release the lock after the loc	upward using right	ase R	n/a		I-marl not al 1. Use th 2. No wr 3. No wr	k is ign	1 hole is open 2 holes are open jig per model tion of connector connector



			WORK IN	Effectivity Date:		November 25, 2021					
		Process Name/Title:	, TAPI	NG ASS	SEMBI	Y PROCES	S	Validity Date:		n/a	
		Model Code/Part Number:	010B / 4\7L0031-	7023	Custo	mer:	TRQSS	Document No.:		WI-ENG-PDE-197A	
		Purpose:	☐ PROTOTYPE		PRE-LA	Customer: TRQSS Document No.: WI-ENG-PDE-1977 PRE-LAUNCH MASSPRO Revision No.: 4 Page No.: 4 3. Black corrugated tube (no slit) ø5 L= 158±3mm 4. Connector 6189-1161 (B) URE/ ILLUSTRATION TOOLS/PPE QUALITY POINTE 1. No wrong use of parts 2. No deformed terminal 1. No deformed terminal 1. No deformed terminal 1. No deformed terminal	4 Page No.: 4 of 9				
PARTS:	1. Assy _I 2. Black	parts corrugated tube (no slit) ø7	_= 156±3mm		3. Black corrugated tube (no slit) ø5 L= 158±3mm 4. Connector 6189-1161 (B)			JIG		1. Insertion jig	
NO.	Р	ROCESS NAME	4 WORK	PROCE	DURE	ILLUSTRATIO	ON	TOOLS/PPE		QUALITY POINTERS	
4		Wire insertion to Black corrugated tube (no slit) Ø7 L= 156±3mm (1ST) Ø5 L= 158±3mm (2ND)	1. Hold the wires using left hand. Get tube (no slit) ø7 L=156±3mm using ri insert then Y-OR wires using left hand	the Corruga		Corrugated tube (r	using left hand. Get the	n/a			
5	P1	Connector setting to insertion jig 6189-1161 (B)	Visual reference Guide	Buttor		Lock		n/a	2. 3.		

				WORK INSTR	UCTION			Effectivity Date:			November	r 25, 2021
		Process Name/Title:		, TAPING A	ASSEMBLY PR	ROCESS		Validity Date:			n/	'a
		Model Code/Part Number:	010B	/ 4\7L0031-7023	Customer:	TRQSS		Document No.:			WI-ENG-F	PDE-197A
		Purpose:	□ F	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:		4	Page No.:	5 of 9
		<u> </u>							ī	1		
PARTS:	n/a			٨					JIG	1. Insert	ion jig	
NO.	F	PROCESS NAME		4 WORK PRO	OCEDURE/ ILLU:	STRATION		TOOLS/	PPE	QI	UALITY F	POINTERS
5	P1	Connector setting to insertion jig 6189-1161 (B) (Continuation)	1. Press the	e lock using left thumb.	sertion jig. Release the ote: Follow the connect	9-1161 (B) using right hand and ir lock after insertion.	elease nsert to	n/a		I-mark I-mark I-mark 1. Use the second of	is align kis not light he provided	1 hole is open 1 hole is open 1 hole is open ig per model tion of connector connector

			WORK INSTRU	JCTION	Effectivity Date:		November 25, 2021		
		Process Name/Title:	, TAPING F	ASSEMBLY PROCESS	Validity Date:		n/a		
		Model Code/Part Number:	010B / 4\7L0031-7023	Customer: TRQ	SS Document No.:		WI-ENG-PDE-197A		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH N	ASSPRO Revision No.:		4 Page No.: 6 of 9		
					-	1			
PARTS:	1. Assy	parts	Λ			JIG	1. Insertion jig		
NO.	F	PROCESS NAME	4 WORK PRO	CEDURE/ ILLUSTRATION	TOOLS/	PPE	QUALITY POINTERS		
6	P1	Wire insertion to connector 6189-1161 (B)	1. Hold the insertion jig using left hand. Get the Yellow wire then insert to termis slot 1 using right hand. Orange wire R 3. Get the Orange wire then insert to terminal slot 2 using right hand.	Press 2. Press the button using slot for Orange wire will be pressed to the pressed of the pres	e opened. Russing left thumb ntly pull out the		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.		



				WORK INSTRUC	TION			Effectivity Date:		November 25, 2021	
		Process Name/Title:		, TAPING AS	SEMBL	Y PROCE	SS	Validity Date:		n/a	
		Model Code/Part Number:	010B	/ 4\7L0031-7023	Custor	ner:	TRQSS	Document No.:		WI- ENG-PDE-197A	
		Purpose:	□PRO	TOTYPE	PRE-LA	UNCH	MASSPRO	Revision No.:		4 Page No.: 8 of 9	
<u> </u>		1						<u> </u>			
PARTS:	1. Assy 2. Black			٨			7L00312 TVSSf 0.3 wires GR-Β nprene tube φ5 L=135±3mm	/W L=678±3mm	JIG	n/a	
NO.	F	PROCESS NAME		4 WORK PROC	EDURE/	ILLUSTRAT	ION	TOOLS/F	PPE	QUALITY POINTERS	
9	P1	Taping 2 Black sunprene tube to wire near hotmelted wires	tube then mea	51±3mm To 1 2 3 4 5 6 7 To 2 3 4 5 6 7 To 3 4 5 6 7 To 3 4 5 6 7 To 4 5 6 7 To 5 7 To 5 8 7 To 5 8 7 To 6 7 To 7 8 7	ands.	the black tape taping process Note: Refer to procedure.	R	Measurin	5 6 7 8 9 6	Note: Please use calibrated/verified measuring tape when getting the measurement.3 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape	

		WORK	INSTRUCTION		Effectivity Date:		November 25	5, 2021
	Process Name/Title:	TAF	PING ASSEMBLY PROC	CESS	Validity Date:		n/a	
	Model Code/Part Number:	010B / <u>4</u> 7L0031	-7023 Customer:	TRQSS	Document No.:		WI-ENG-PDE	E-197A
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		WI-ENG-PDE-1 4 Page No.:	9 of 9
ARTS:	y parts ck Corrugated tube (no slit) φ7	L=326±3mm				JIG	Terminal cover jig	
NO.	PROCESS NAME	WOR	K PROCEDURE/ ILLUSTR	ATION	TOOLS/	PPE	QUALITY PO	INTER
		L		terminal cover jig using right hand to both terminals (GR-B/W wires) hand.				
	Wire insertion to	L	2 Get the	corrugated tube ф7 L=326±3mm	TERMINAL CO	VER JIG		

L

3. After insertion, remove the cover jig using right hand.

using right hand then insert the GR-B/W wires

using left hand.

No wrong usage of parts
 No damaged rubber seal

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Black Corrugated tube

(no slit) \$\phi T = 326 \text{\text{\text{\text{\$}}} 326 \text{\text{\$}} 326 \text{\t

10

P1