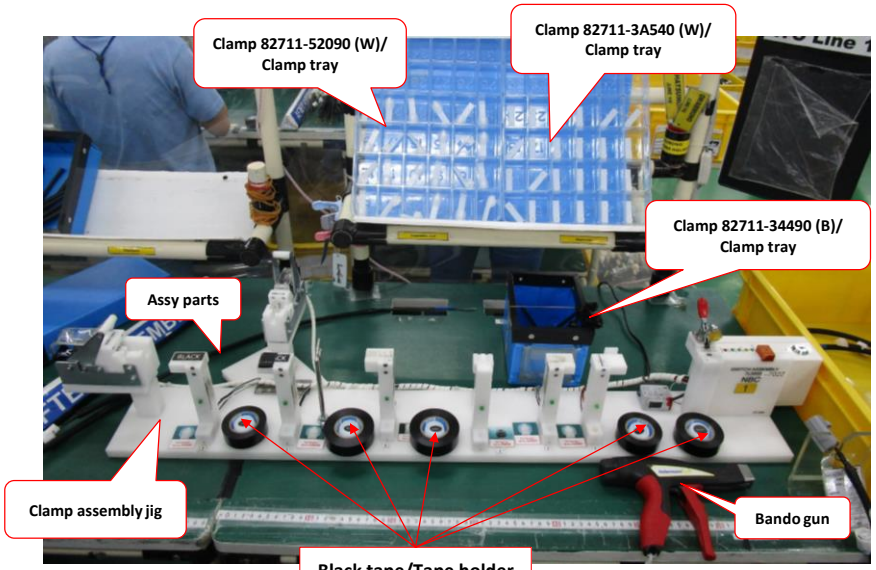
	WORK INSTRUCTION			Effectivity Date:	January 18, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	150B / 2 7L0059-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-291C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.:	1 of 6

PARTS:	2 1. All parts: Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [5pcs.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	2 Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required 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
01/18/22	2	Change part number from 7L0059-7021 to 7L0059-7022 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				
08/05/21	1	Transfer process owner from Production (WI-PRO-ASY-150C) to Engineering (WI-ENG-PDE-291C). Improve process illustration and quality pointers.	J. Loterte	C.Villanueva	A. Shimamura	A. Arañes				
08/10/19	0	Previously established in Production. Initial issue.	J. Silang	W. Carbillon	O. Merin	n/a	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 10, 2019		

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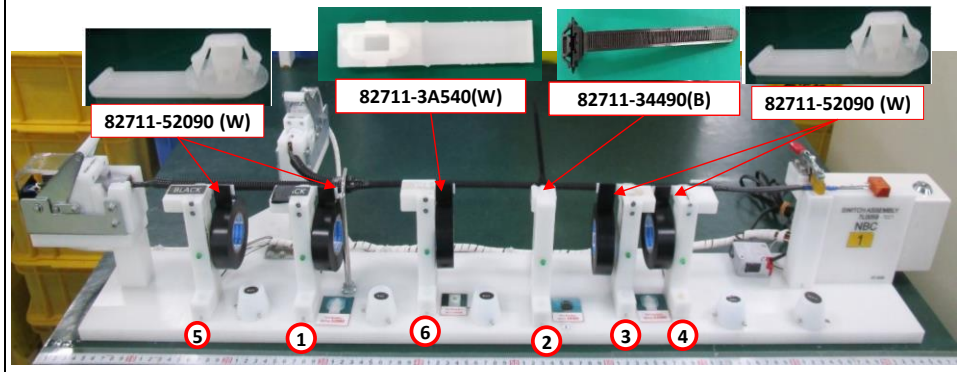
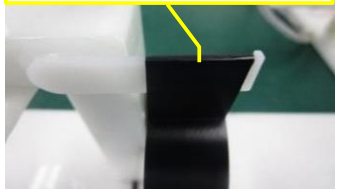
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a	
	Model Code/Part Number:	150B / 2 7L0059-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-291C	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 2 of 6

PARTS:	1. Clamp 82711-52090 (W) [4pcs.] 2. Clamp 82711-3A540 (W) 3. Clamp 82711-34490 (B) 4. Black tape [5pcs.]	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting	 2 1. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **5 and 1** using both hands. 2. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **3 and 4** using both hands. 3. Get 1 pc. of clamp **82711-3A540 (W)** using right hand then insert to clamp location **6** using both hands. **Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.** 4. Get 1 pc. of clamp **82711-34490 (B)** using right hand then insert to clamp location **2** using both hands. 5. Get the **Black tape** then initially attach to clamp location **5, 1, 6, 3 and 4** using both hands.	n/a	**STANDARD TAPING FOR CLAMP** One side tape under clamp  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wvrong clamp position

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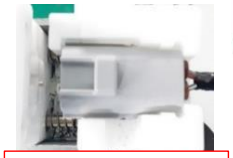
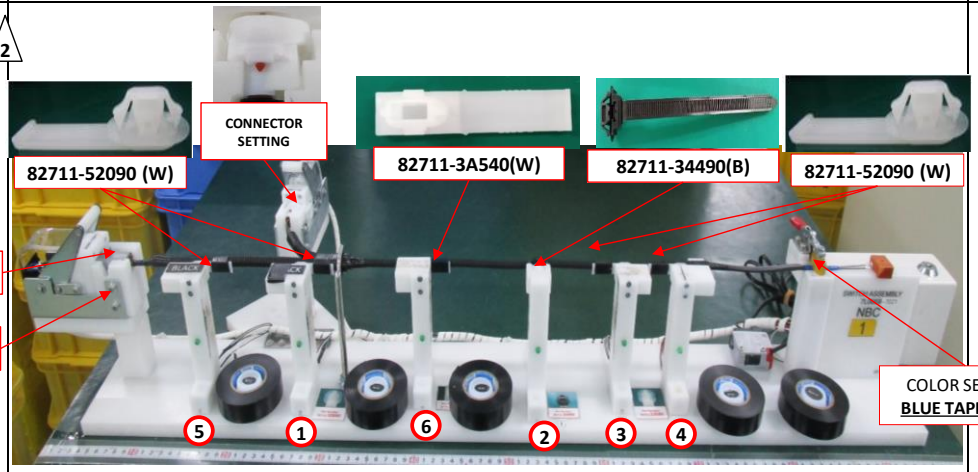
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a	
	Model Code/Part Number:	150B / 2 7L0059-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-291C	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 3 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	 CONNECTOR SETTING CHECKER 1  1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Continue to set the harness in jig. **Color sensor** light will beep/buzz if sensor detects **Blue tape.** Last, set the terminal end within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON.** 2. 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. 3. Hold the tape on clamp location **1,** make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **2** was **ON.**	n/a	 *Make sure no gap between terminal and stopper jig* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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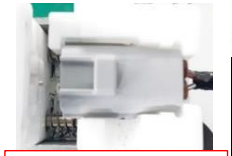
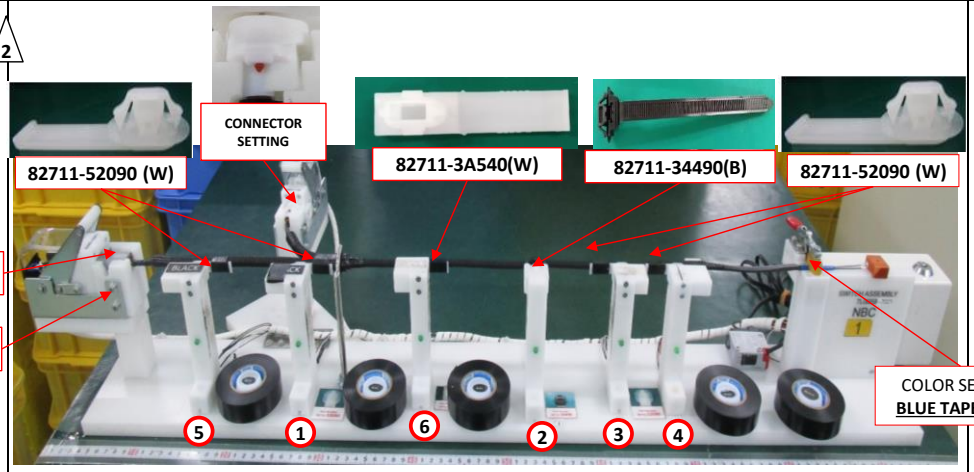
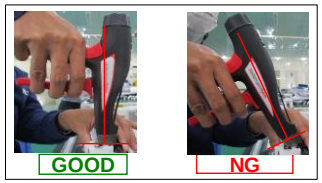
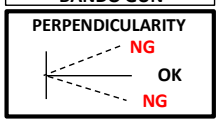
	Model Code/Part Number:	150B / 2 7L0059-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-291C	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 4 of 6

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

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	2  CONNECTOR SETTING CHECKER 1  4. Initially tighten the band clamp on clamp location **2** using both hands. 5. Get the bando gun using right hand then cut the band clamp on location **2** using both hands. Press the **SW button** after cut. Continue the process if sequence light on clamp location **3** was **ON.**  BANDO GUN PERPENDICULARITY  **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: 1~ 2	n/a	2 *Make sure no gap between terminal and stopper jig* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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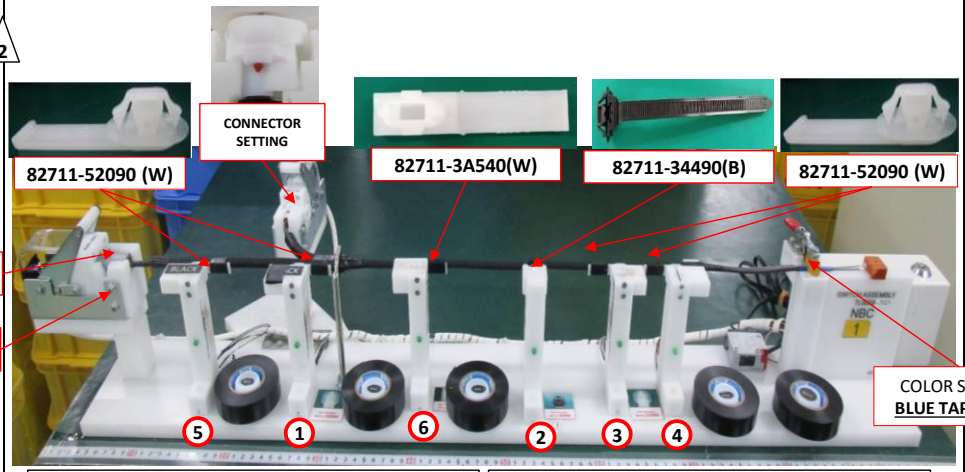
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.:	5 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly (Continuation)	 6. Hold the tape on clamp location **3**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **4** was **ON.** 7. Hold the tape on clamp location **4**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **5** was **ON.** 8. Hold the tape on clamp location **5**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **6** was **ON.** 9. Hold the tape on clamp location **6**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard. 10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.	n/a	 *Make sure no gap between terminal and stopper jig* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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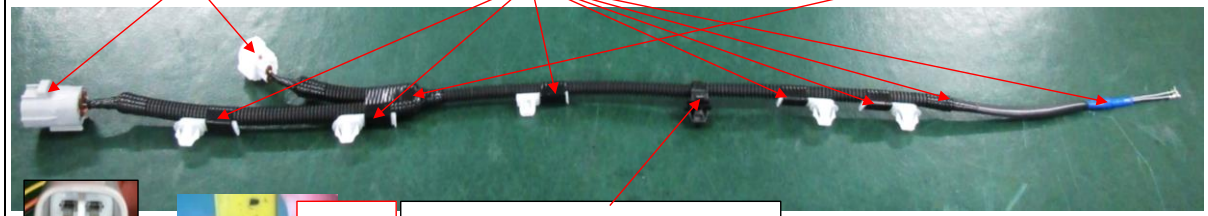
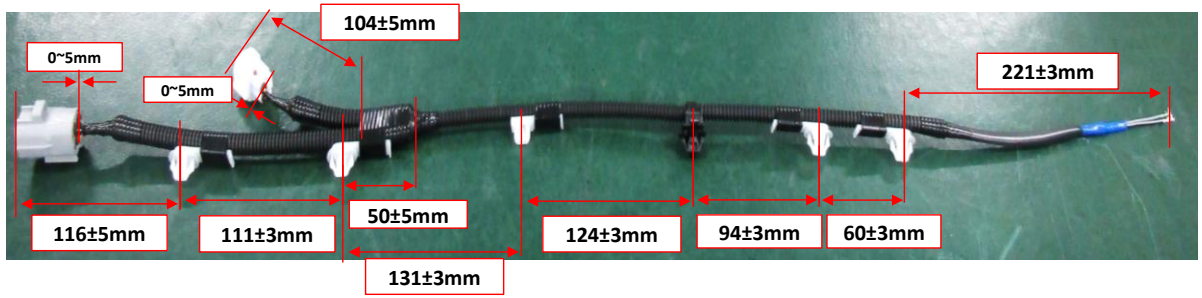
PARTS:	n/a	JIG	n/a

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

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