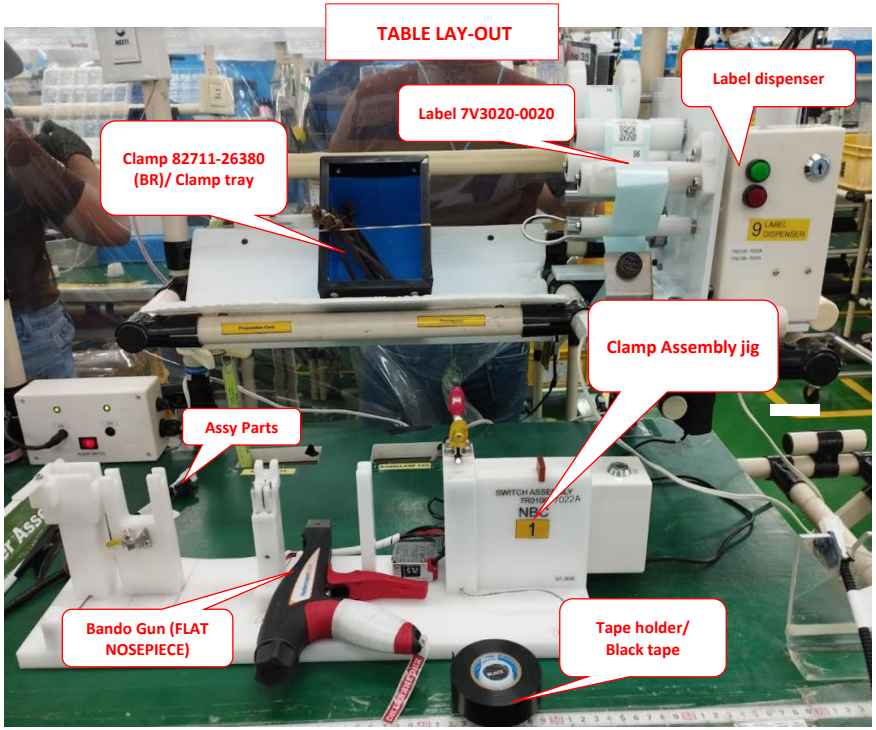
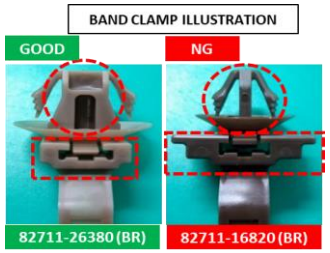
	WORK INSTRUCTION			Effectivity Date:	April 26, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	780B / 7R0106-7022A	Customer: TRMX	Document No.:	WI-ENG-PDE-565B		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	1 of 8

PARTS:	1. Assy parts; Clamp 82711-26380 (BR); Black tape; Label 7V3020-0020	JIG:	1. Clamp assembly jig 2. label dispenser

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	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 work place 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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
4/26/23	3	Inclusion of quality checkpoints	J. Loterte	C.Villanueva	A.Arañes	n/a
10/28/22	2	Improve Quality pointers: Reminders/Notes and references on page no. 1,2,3,4,5,6 and 8; Improve work procedure/Illustration on process no.6- Visual/ By two's inspection due to process improvement.	M. Ariola	J. Loterte	C.Villanueva	A.Arañes
07/28/22	1	Change from pre-Launch to Masspro. Change table lay-out	M. Ariola	J. Loterte	C.Villanueva	A.Arañes
07/20/22	0	Initial Issue QR Code 7V3020-0020 Label direction.	M. Ariola	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 20, 2022

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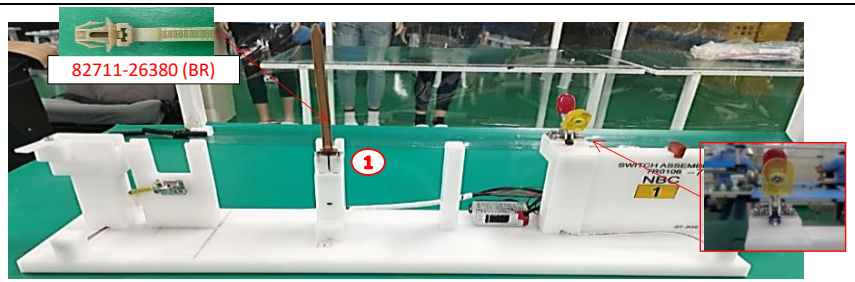
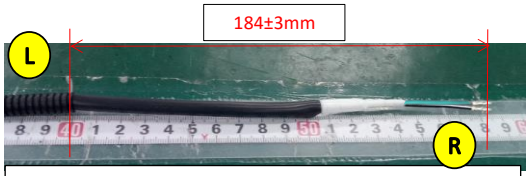
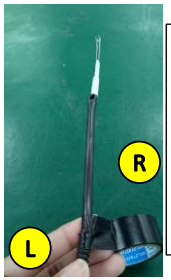
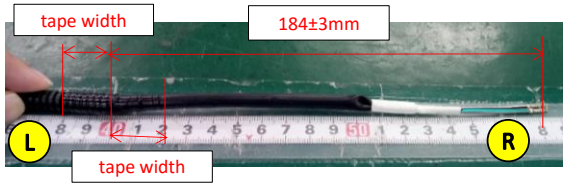
NBC	WORK INSTRUCTION			Effectivity Date:	April 26, 2023
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model Code/Part Number:	780B / 7R0106-7022A	Customer: TRMX	Document No.:	WI-ENG-PDE-565B
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3 Page No.: 2 of 8

PARTS:	1. Clamp 82711-26380 (BR) 2. Black tape 3. Assy parts	**JIG**	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp Setting	 Get 1pc of Band clamp 82711-26380 (BR) using right hand and set to clamp location 1.	n/a	1. No wrong use of clamp 2. No damaged clamp ***Important reminders/Note/s:*** *1. Please check the clamp before start of assembly to avoid wrong use of clamp.*
3		Taping 1 COT to Sunprene tube near terminal	 1. Get the assy parts. Hold the COT using left hand. Measure from end of COT up to the terminal pointed tip 184±3mm.  2. Hold the COT using left hand. Get Black tape using right hand and start taping using both hands. Make sure no gap between COT and Sunprene tube.  3. After taping, check the measurement and taping condition.	Measuring Tape 	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6.No missing tape ***Important reminders/Note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.*

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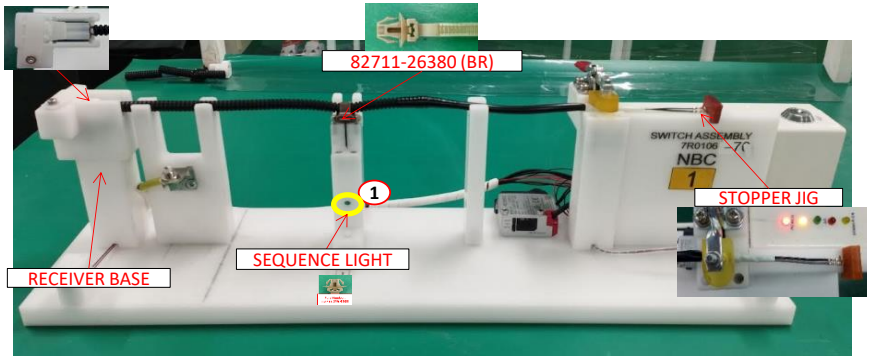
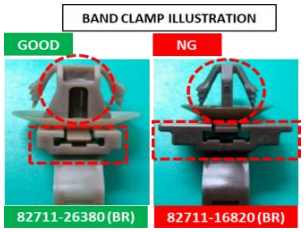
	WORK INSTRUCTION			Effectivity Date:	April 26, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/ Part Number:	780B / 7R0106-7022A	Customer: TRMX	Document No.:	WI-ENG-PDE-565B		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	3 of 8

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly	 1. Get the assy parts and set into jig. ***(See above picture for correct setting).*** First, set the connector **6188-0407 (W)** to **Checker 1** then lock. Second, set the **G-B/W wires** together within the stopper jig**.** Color sensor will be beep/buzz if detected white tape. pull down the toggle clamp using right hand. Continue if the sequence light in location **1** was **ON.** 2. Check if LED light for POWER, CLAMP, COLOR SENSOR and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction. 3. Initially tighten the clamp on location 1 using both hands.		1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment ***Important reminders/Note/s:*** *1. Make sure no gap between the terminal and stopper jig.* *2. You will hear the NG buzzer if the sensor detect the wrong use of tape and missing tape.* 

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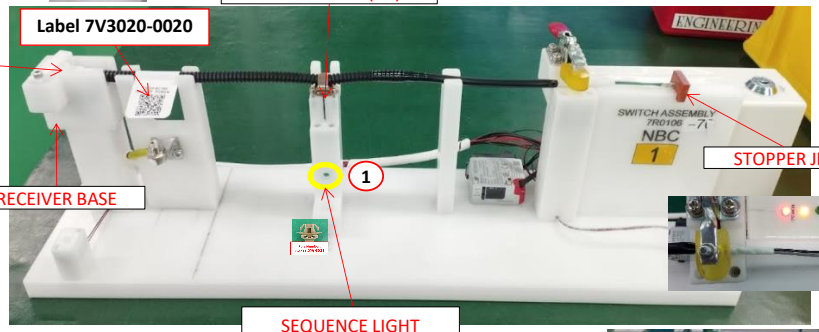
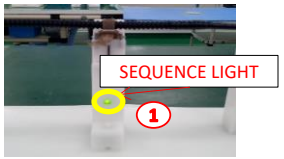
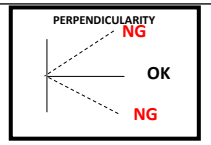
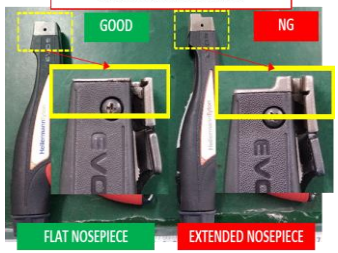
PARTS:	1. Assy parts	**JIG**	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly (Continuation)	 CONNECTOR SETTING 82711-26380 (BR) Label 7V3020-0020  STOPPER JIG RECEIVER BASE SEQUENCE LIGHT 4. Get the bando gun and cut the clamp on location 1. Press the SW button after cutting. Continue on label Attachment. *(Refer to the next page for label attachment.*  5. 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. BANDO GUN ALIGNMENT 6. Conduct **POINT CHECKING** before removing the harness from jig. Fixed setting of band clamp cutter: 3 ~ 4  	BANDO GUN FLAT NOSEPIECE	1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment ***Important reminders/Note/s:*** *1. Make sure no gap between the terminal and stopper jig.* *2. You will hear the NG buzzer if the sensor detect the wrong use of tape and missing tape.* *3. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.* For: ø5 - 1~2, ø7 - 3~4 

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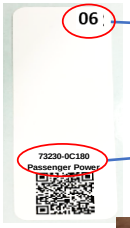
	Model Code/Part Number:	780B / 7R0106-7022A	Customer: TRMX	Document No.:	WI-ENG-PDE-565B	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.: 5 of 8

PARTS:	1. Assy parts 2. Label 7V3020-0020	JIG	1. Clamp Assembly jig 2. Label dispenser

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	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

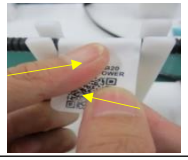
Item no. & name

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

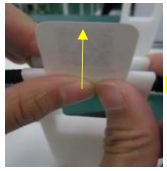
2. Align the end part of label in the jig.

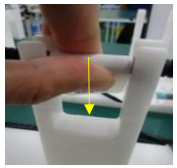
3. Fold the center part of the label

4. Align both end part of label.

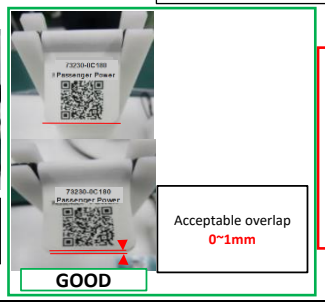


5.After alignment , Press the label with both fingers .





6. Press the label upside down using finger.



Acceptable overlap
0~1mm

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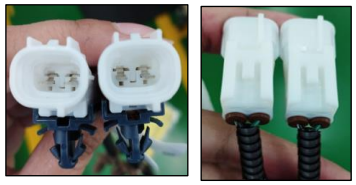
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	6 of 8

PARTS:	1. Assembed parts 2. Master sample	JIG	n/a

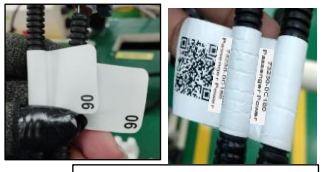
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Visual/By two's inspection			

1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **connector lock, insertion and terminal.**

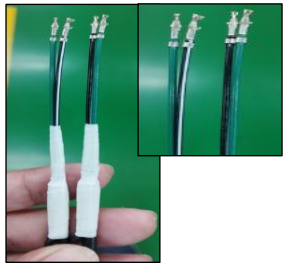
3. Check the **presence of clip clamp attachment.**



4. Check the **presence** and **condition of QR code Label**.

5. Check the **presence of clamp attachment** and **band clamp cut.**

6. Check the **presence of tape** and **taping condtion**.



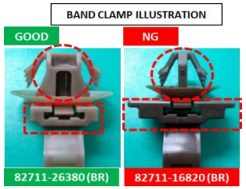
7. Check the **taping condition, color of tape (White tape only), terminal appearance**. Must be **no deformed terminal.**

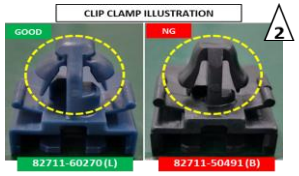
1. No skip checking during inspection.

MASTER SAMPLE

Important reminders/Note/s:

1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).





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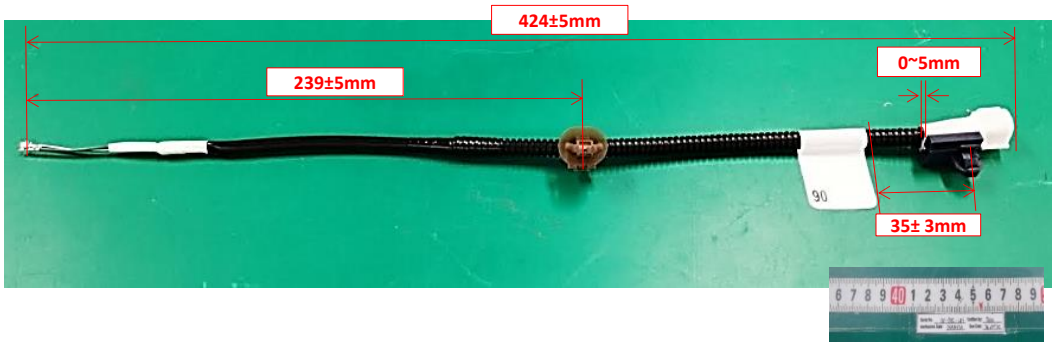
PARTS:	n/a	**JIG**	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Measurement			1. No wrong dimension. ***Important reminders/Note/s:*** *1. Please use calibrated/verified measuring tape when gettig the measurement.* *2. For Hatsumono and Owarimono.*

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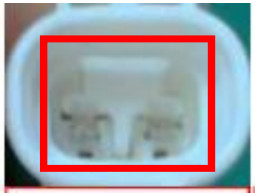
PARTS:	1. Assy parts	**JIG**	n/a

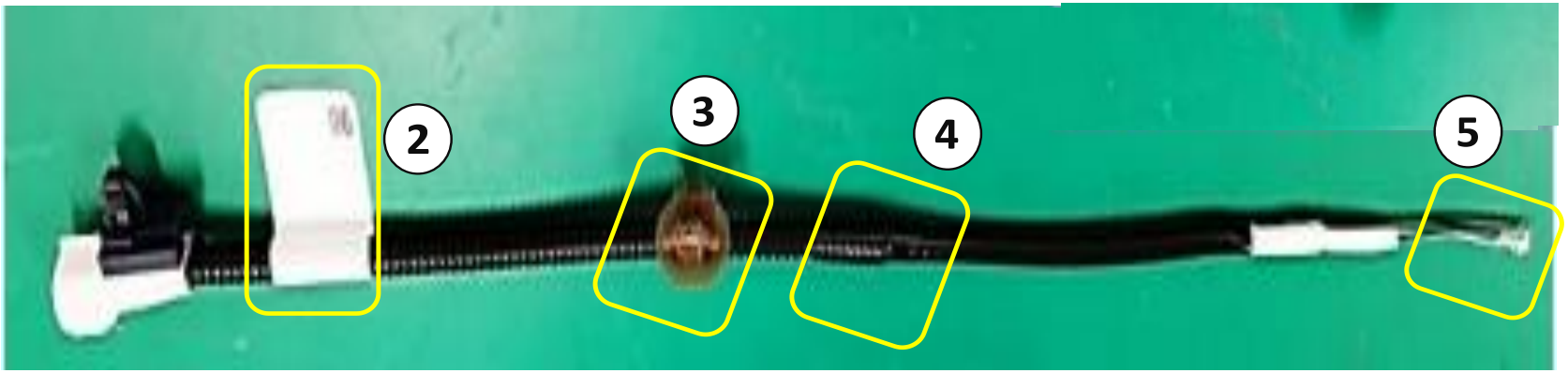
3 QUALITY CHECKPOINTS

P2 7R0106-7022A

GOOD



NO GOOD



1. No Unlock Connector
2. No Missing/Wrong Use of Bardcode
3. No Missing Band Clamp
4. No Missing Tape
5. No Deformed Terminal
6. Checking of loose/tight band clamp

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