
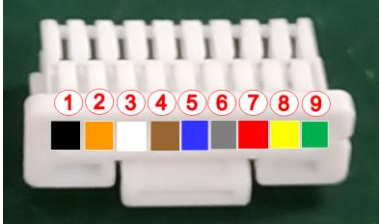

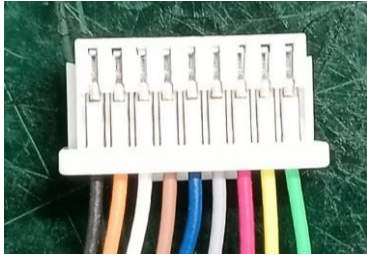
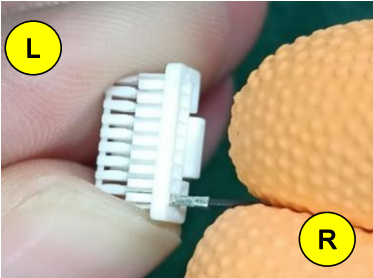





| | | | | | | | | |
|---|---|--|-----------------------|------------------------|-------------------|--|-----------------------|------------------|
|  | WORK INSTRUCTION | | | | Effectivity Date: | | March 5, 2024 | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: U759/U760 / 75U001-0210 | | Customer: TRMX | Car Model: FORD | Document No.: | | WI-ENG-PDE-810 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO | | | | Revision No.: | | 0 | Page No.: 1 of 6 |


| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---------------|---------------------|---|-----|-----|-----|------------------|-------------------------|-----|---|---|---|---|---|---|---|----|---|----|---|----|---|---|---|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|---|
| PARTS: | | 1. Beamex-NF 0.035 wire B L=106±1mm; OR wire L=106±1mm; W wire L=106±1mm; BR wire L=106±1mm; L wire L=106±1mm; GR wire L=106±1mm; R wire L=106±1mm; Y wire L=106±1mm; G wire L=106±1mm 2. Connector NSHR-09V-S (W) [1pc] | | | | JIG: | n/a | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | | TOOLS/PPE | QUALITY POINTERS | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | P1 | <div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td></tr><tr><td>B</td><td>OR</td><td>W</td><td>BR</td><td>L</td><td>GR</td><td>R</td><td>Y</td><td>G</td></tr><tr><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td></tr></table><div>WIRE FACING</div></div> <div>1. Get 1pc of Connector NSHR-09V-S (W) then get the B wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to OR-W-BR-L-GR-R-Y-G wires. Note: Follow the insertion sequence based on the illustration.</div> | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | B | OR | W | BR | L | GR | R | Y | G | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | <div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> | <div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminders/Note/s: <i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</i></div> <div>Document reference/s: <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div> |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | | | | | | | | | | | | | | | | | | | | | | | | | |
| B | OR | W | BR | L | GR | R | Y | G | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | | | | | | | | | | | | | | | | | | | | | | | | | | |

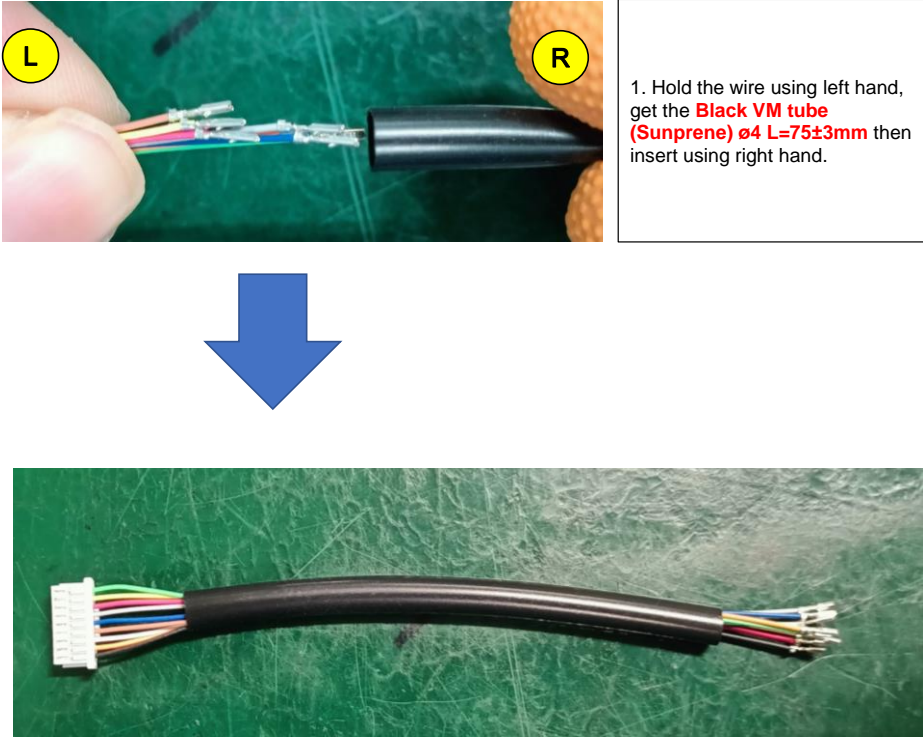
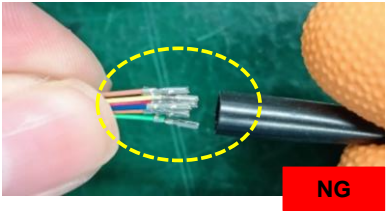
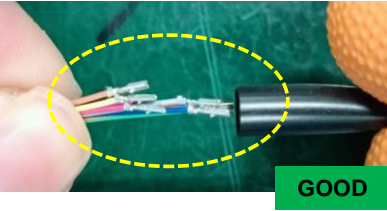
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| Revision History | | | | Prepared by | Reviewed by | Approved by | Noted by |
| 03/05/24 | 0 | Initial issue. | |  D. Castillo |  C. Villanueva |  A. Arañes | n/a |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: March 5, 2024 |

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|  | WORK INSTRUCTION | | | | Effectivity Date: | March 5, 2024 | | | |
| | TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | | |
| | Process Name/Title: | | Model code/Part number: U759/U760 / 75U001-0210 | | Customer: TRMX | Car Model: FORD | Document No.: | WI-ENG-PDE-810 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO | | Revision No.: | | 0 | Page No.: | 2 of 6 | | |

| | | | | | |
|---------------|---------------------|---|--|------------------|--|
| PARTS: | | 1. Assy part 2. Black VM tube (Sunprene) ø4 L=75±3mm | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P1 | <div><div></div><div>1. Hold the wire using left hand, get the Black VM tube (Sunprene) ø4 L=75±3mm then insert using right hand.</div></div> | | n/a | <div><div>1. No wrong use of parts 2. No deformed terminal</div></div> |

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 5, 2024

Model code/Part number:

U759/U760 / 75U001-0210

Customer:

TRMX

Car Model:

FORD

Document No.:

WI-ENG-PDE-810

Purpose:

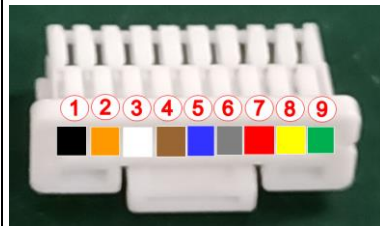


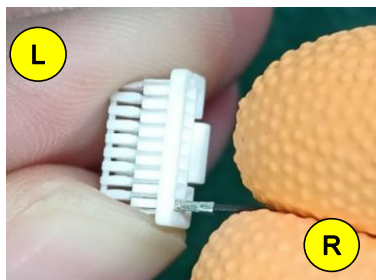
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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0

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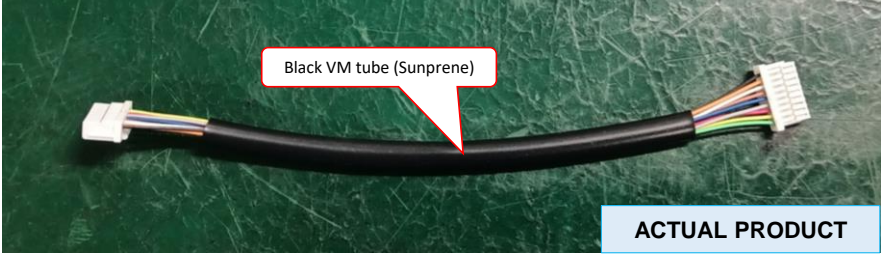
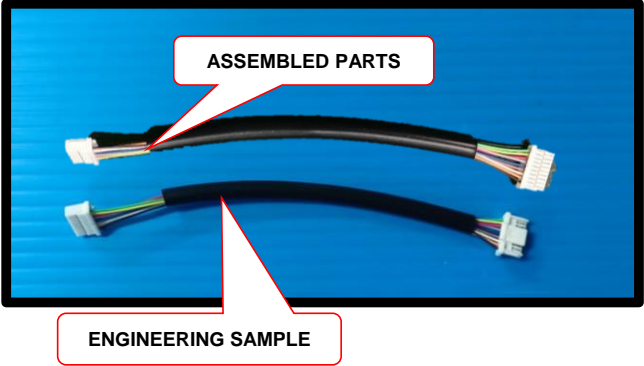

| PARTS: | | 1. Assy part 2. Connector NSHR-09V-S (W) [1pc] | | JIG: | n/a | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--------|--------------|---|-----|-----------|------------------|-----|-----|-----|---|---|---|---|---|----|---|----|---|----|---|---|---|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | P1 | <div><div><table><tr><th>1</th><th>2</th><th>3</th><th>4</th><th>5</th><th>6</th><th>7</th><th>8</th><th>9</th></tr><tr><td>B</td><td>OR</td><td>W</td><td>BR</td><td>L</td><td>GR</td><td>R</td><td>Y</td><td>G</td></tr><tr><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td><td>106</td></tr></table></div><div><div>WIRE FACING</div></div><div></div><div>1. Get 1pc of Connector NSHR-09V-S (W) then hold the B wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to OR-W-BR-L-GR-R-Y-G wires. Note: Follow the insertion sequence based on the illustration.</div></div> | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | B | OR | W | BR | L | GR | R | Y | G | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | n/a | <div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after inserion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | | | | | | | | | | | | | | | | | | | | | | | |
| B | OR | W | BR | L | GR | R | Y | G | | | | | | | | | | | | | | | | | | | | | | | | |
| 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | | | | | | | | | | | | | | | | | | | | | | | | |

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| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | |
| | Model code/Part number: U759/U760 / 75U001-0210 | | Customer: TRMX | Car Model: FORD | Document No.: | WI-ENG-PDE-810 | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO | | | | Revision No.: | 0 | Page No.: | 4 of 6 |


| | | | | | |
|---------------|---------------------|---|--|------------------|---|
| PARTS: | 1. Assy part | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P1 | Visual/By two's inspection | | n/a | 1. No skip checking during inspection |
| | | <div>1. Check the wire alignment. Make sure no tangled wires.</div> <div>2. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div></div> <div>3. Compare to Engineering sample by tapping.</div> <div></div> | | | <div>MASTER SAMPLE</div> <div></div> |

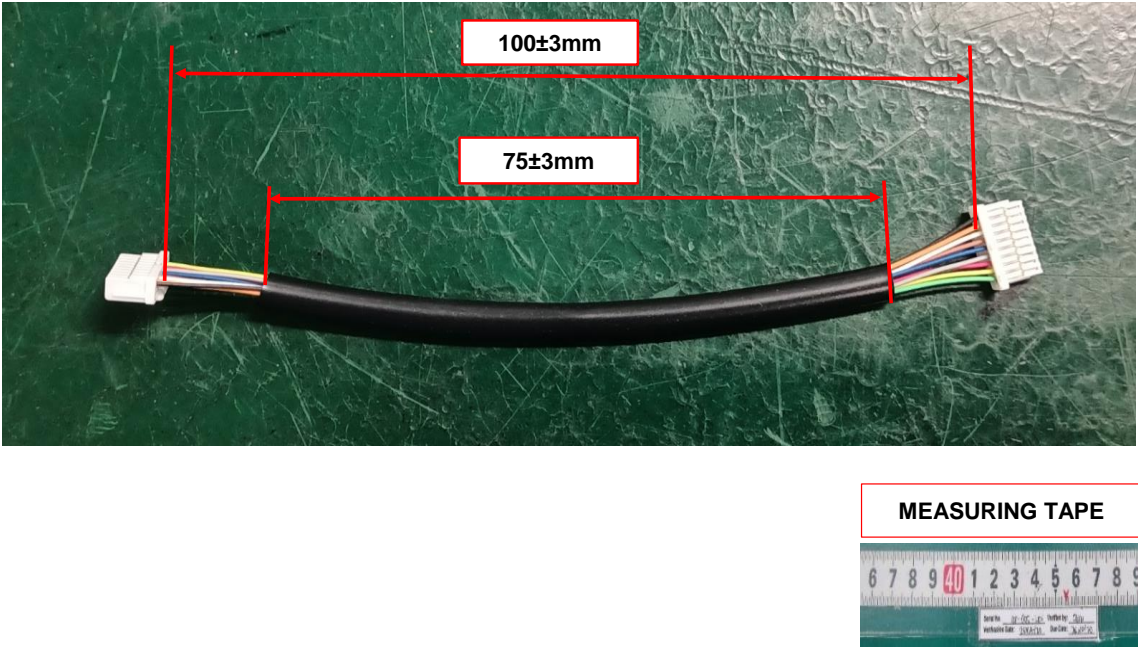

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| | | | | | |
|---------------|---------------------|-------------------------------------|--|---|--|
| PARTS: | 1. Assy part | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P1 | Measurement | <div></div> | <div>MEASURING TAPE</div>  | <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No wrong dimension</p> |

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WORK INSTRUCTION

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Validity Date:

n/a

Model code/Part number: U759/U760 / 75U001-0210

Customer: TRMX

Car Model: FORD

Document No.:

WI-ENG-PDE-810

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

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PARTS:

n/a

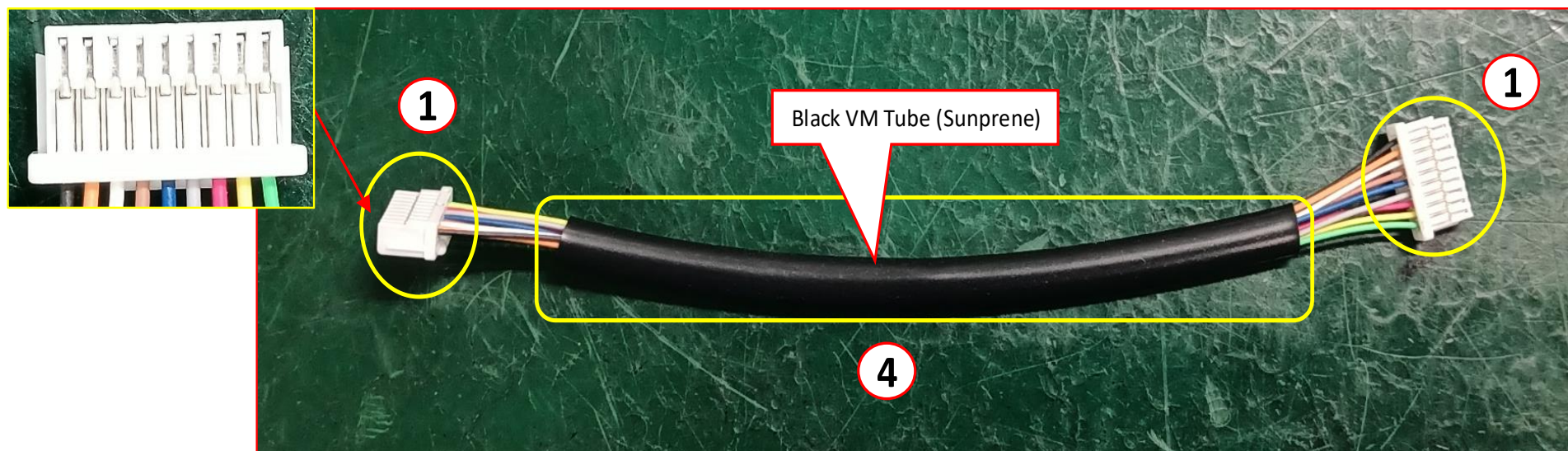
JIG:

n/a

QUALITY CHECKPOINTS

P1

75U001-0210



① No Wrong Insert

③ No Backing out of terminal

② No Tangled wires

④ No Missing VM tube (Sunprene)

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